

## WELDSKILL 70S-6



- ▲ A manganese-silicon alloy solid wire for GMAW welding of mild & low alloy steels
- ▲ Designed for Use with CO<sub>2</sub> and Argon Based Shielding Gases.
- ▲ Great quality copper coated wire.

### Classifications:

ISO AS/NZS 14341: B G 49A 3U C1/M21/M24 S6  
 ISO AS/NZS 14341: A G 38 2 C 1 Z 3Si1  
 AWS/ASME-SFA A5.18: ER70S-6

### Description and Applications:

Weldskill 70S-6 is a good quality copper coated welding wire suitable for the all positional Gas Metal Arc Welding (GMAW) of mild and low alloy steels, used in general fabrication and structural work. The copper coating ensures problem free feeding, smooth current pick-up and minimal contact tip wear. The higher silicon content of Weldskill 70S-6 ensures great operator appeal, fillet shape / side wall wash at weld toes and low spatter levels important for welding light to medium gauge sheet and tubular steel sections.

### Storage Recommendations:

When held under the recommended storage conditions unopened packs of Weldskill 70S-6 wires are expected to remain in 'factory fresh' condition for at least 12 months. For storage over 12 months or under adverse (damp or high humidity) climatic conditions the use of heated weather proof store rooms/cupboards/containers maintained at 10-15°C above ambient temperature (with a maximum of 40°C) and at a maximum humidity of 60% R.H. is recommended. Product should be stacked on racks or pallets clear of the floor and walls.

### TYPICAL WIRE ANALYSIS:

C: 0.07%	Mn: 1.55%	
S: 0.012%	P: 0.015%	Si: 0.88%

### TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

1.0 - 2.0 mls of hydrogen / 100gms of deposited weld metal.

### TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

	Argon + 18-25% CO <sub>2</sub>	Welding Grade CO <sub>2</sub> :
Yield Stress	>420 MPa	>400 MPa
Tensile Strength	500-600 MPa	>480 MPa
Elongation	>22%	>22%
CVN Impact Val.	>47 J @ -30°C	>27 J @ -30°C

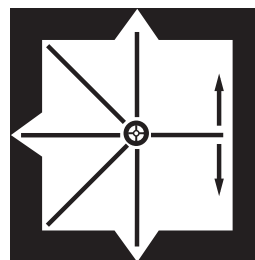
### RECOMMENDED\* SHIELDING GAS:

AS 4882:	ISO 14175 / AWS A5.32:
SG-AC-8, or SG-AC-10	M20
SG-AC-18, or SG-AC-20	M21*- Cert supplied
SG-AC-5/2	M23
SG-C	C1

Ar+CO<sub>2</sub> (8-25%) or Ar+CO<sub>2</sub>+O<sub>2</sub> or Welding Grade CO<sub>2</sub>

### COMPARABLE CIGWELD PRODUCTS:

Comweld LW1-6 TIG rod:  
 AWS/ASME-SFA A5.18: ER70S-6



All positional welding applications

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**Packaging and Operating Data:**

Wire Diameter mm	Voltage Range (volts)	Wire Feed Speed (meters/min)	Current Range (amps)	Pack Type	Pack Weight	Part No
0.6	12–14	3.5–14	35–100	Handy Spool	5kg	WS0506
0.8	14–22	3.5–14	50–180	Handy Spool	5kg	WS0508
				Spool	15kg	WS1508
0.9	15–26	3.5–15	70–230	Handy Spool	5kg	WS0509
				Spool	15kg	WS1509
				Drum	250kg	WS25009
1.0	16–29	3.5–15	100–280	Spool	15kg	WS1510
1.2	18–32	2.5–15	120–350	Spool	15kg	WS1512
				Drum	250kg	WS25012
1.6	18–34	2.5–10	180–390	Spool	15kg	WS1516

\* Mini Spool (ø100mm); Handy Spool (ø200mm); Spool (ø300mm) AutoPak (ø510mm x H.840mm)