



a quality welding alloy

## ARCtec® ER70S-6

Conforms to: AWS A5.18 Class ER70S-6  
 Certified by CWB to CSA W48-06 E49S-6

### GENERAL CHARACTERISTICS:

ARCtec® ER70S-6 is a copper coated welding wire for general purpose welding. This wire permits the use of high welding currents when using CO<sub>2</sub> as a shielding gas. May be used in short circuiting or spray transfer mode. The high amount of deoxidizers helps produce a stable quiet arc. This filler material can also be used out of position in the short circuiting transfer mode.

### APPLICATIONS:

ARCtec® ER70S-6 is recommended for single or multipass welds on low carbon steel plate, tubing, structural members and general repair work on low carbon steel components.

### TYPICAL MECHANICAL PROPERTIES: (CO<sub>2</sub> SHIELDING GAS)

Tensile Strength (Min.) 78,300psi 540MPa	Yield Strength (Min.) 62,400psi 430MPa	Elongation 28%-2"	Impact Strength 52 ft/lb 70 joules	Test Temperature -20°F/-29°C
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### TYPICAL CHEMICAL COMPOSITION: (UNDILUTED CO<sub>2</sub> SHIELDING GAS)

Mn	Si	C	P	S	Fe
1.55	.85	.08	.015	.018	Bal.

### OPERATING PARAMETERS:

WELDING PROCESS: GMAW      POLARITY: DC Reverse

SHIELDING GAS AND FLOW RATE  
 CO<sub>2</sub> or 75% Argon/25% CO<sub>2</sub> at 30-40 CFH

Operating Range- (CO <sub>2</sub> Shielding Gas)					Operating Range - (75% Argon/25% CO <sub>2</sub> Shielding Gas)				
	Diameter					Diameter			
	.035" (.90mm)		.045" (1.2mm)			.035" (.90mm)		.045" (1.2mm)	
Welding Position	Volts	Amps	Volts	Amps	Welding Position	Volts	Amps	Volts	Amps
Fillet	27-33	190-230	28-32	240-290	Fillet	29-31	190-210	28-33	250-290
Vertical Up	20-24	100-130	20-24	120-160	Vertical Up	20-22	130-150	19-27	130-170
Vertical Down	30-33	200-220	27-32	240-280	Vertical Down	27-29	190-210	27-32	240-280
Over Head	24-27	140-160	21-26	130-170	Over Head	22-25	140-160	21-23	160-190

### STANDARD SIZE AND PACKAGING:

Size	12" spools
.035" .90mm	20 Kg
.045" 1.2mm	20 Kg

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Subject to change without notice

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