

MILD STEEL MIG WELDING WIRE

DESCRIPTION

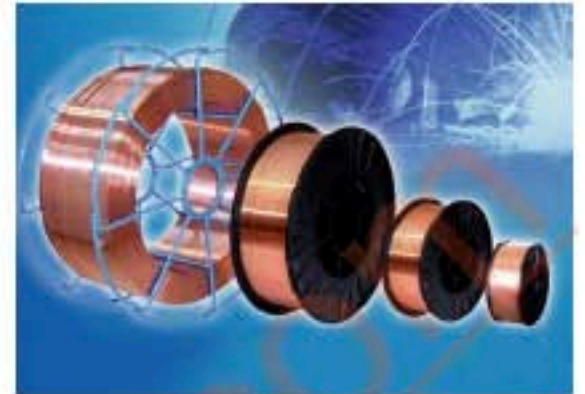
ER70S-6 can be used for CO₂+Ar solid welding wire or CO₂ solid welding wire. With excellent welding technological properties, stable arc, less spatter, a higher deposition efficiency. It is suitable for all positions.

APPLICATION

The welding wire is used for welding low carbon structural steel and low alloy steel. Such as ships, heavy-duty machines, pressure vessel etc.

Chemical composition of wire: (%) Accord with GB/T8110-95

C	Mn	Si	S	P	Cu
0.1	1.54	0.9	0.02	0.018	0.1

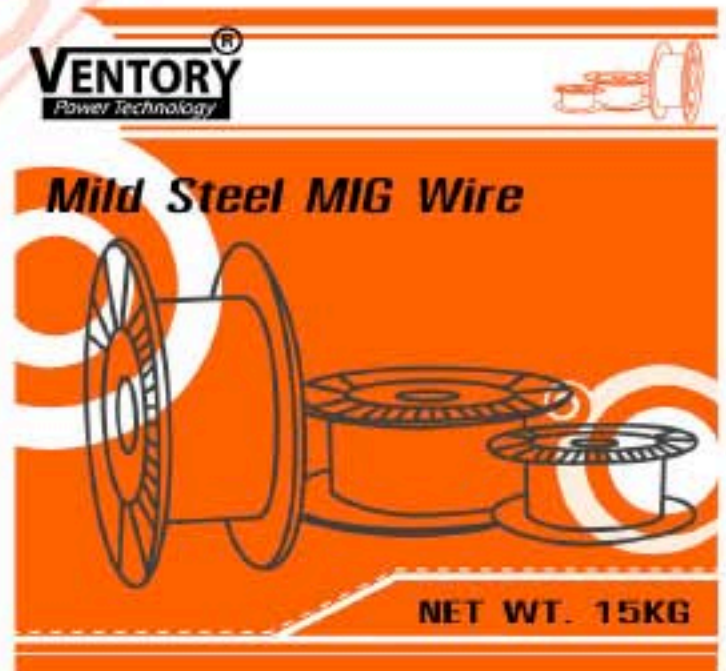


Typical mechanical properties of deposited metal: Accord with GB/T8110-95

Yield point $\sigma_{0.2}$ Mpa	Tensile Strength $\sigma_{0.2}$ Mpa	Elongation $\sigma_{5\%}$	V-Type Charpy Impact	Value (ambient temp.)J
440	525	25.5	46	46

Sizes of wire: Diameter Φ (mm) 0.6, 0.8, 0.9, 1.0, 1.2, 1.6, 2.0

mm	Spool	Package	Inner Bag	KG N.T.	Wound
0.6	basket spool & plastic spool	carton	polyethylene	1	Layer Wound
0.8					
0.9					
1.0					
1.2					
1.4					
1.6					



List of Welding Wires For Gas Shielding Arc Welding

Cu: (%) include copper-coated layer.

AWS	GB/T8110-95	Chemical composition of welding wire									
		C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
ER70S-4	ER50-4	0.07~0.15	1.00~1.50	0.65~0.85	≤0.035	≤0.025					≤0.50
ER70S-6	ER50-6	0.06~0.15	1.40~1.85	0.80~1.15	≤0.035	≤0.025					≤0.50
ER80S-B2	ER55-B2	0.07~0.12	0.40~0.70	0.40~0.70	≤0.025	≤0.025	≤0.20	1.20~1.50	0.40~0.65		≤0.35
ER90S-B3	ER62-B3	0.07~0.12	0.40~0.70	0.40~0.70	≤0.025	≤0.025	≤0.20	2.30~2.70	0.90~1.20		≤0.35
ER80S-D2	ER55-D2	0.07~0.12	1.60~2.10	0.50~0.80	≤0.025	≤0.025	≤0.15		0.40~0.60		≤0.50
ER100S-1	ER69-1	≤0.80	1.25~1.80	0.20~0.50	≤0.010	≤0.010	1.40~2.10	≤0.30	0.25~0.55	≤0.05	≤0.25