

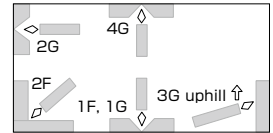
**Solid wire**

- Features:**
- Higher currents can be applied in vertical and overhead positions
  - Suitable for pipe welding in all positions

**Classification:** AWS A5.18 ER70S-6

**Shielding gas:** CO<sub>2</sub>, Ar-20%CO<sub>2</sub>

**Polarity:** DCEP

**Welding Positions:****Packaging data**

φ mm	Spool	Drum	
		-	-
0.9	20kg	-	-
1.0	20kg	250kg	-
1.2	20kg	-	300kg
<b>Volume mm</b>	300W, 110H, 300L	530 φ, 820H	

**Composition (wire mass%)**

	Typical (CO <sub>2</sub> )	Guaranty <sup>a</sup>
<b>C</b>	0.10	0.06~0.15
<b>Si</b>	0.88	0.80~1.15
<b>Mn</b>	1.56	1.40~1.85
<b>P</b>	0.011	0.025
<b>S</b>	0.012	0.035
<b>Ni</b>	0.01	0.15
<b>Cr</b>	0.02	0.15
<b>Mo</b>	<0.01	0.15
<b>Cu</b>	0.24	0.50
<b>V</b>	<0.01	0.03

Note: <sup>a</sup> Single values are maximum.

**All-weld mechanical properties**

	Typical		Guaranty
	CO <sub>2</sub>	Ar-20%CO <sub>2</sub>	
<b>0.2%YS (MPa)</b>	470	520	400min.
<b>TS (MPa)</b>	560	600	483min.
<b>EI on 4d (%)</b>	32	31	22min.
<b>IV -29°C (J)</b>	70	90	27min.
<b>SG</b>	CO <sub>2</sub>	Ar-20%CO <sub>2</sub>	CO <sub>2</sub>

**Welding parameters (A)**

φ mm	1F, 1G, 2F	2G	3G uphill	4G
0.9	50~200	50~180	50~140	50~120
1.0	50~220	50~200	50~140	50~120
1.2	80~350	80~300	50~160	50~140