

# SPECIFICATION SHEET

## ER70S-6 - SOLID MILD STEEL WELDING WIRE



**Features: -**

A general purpose mild steel welding wire suitable for MIG (GMAW) applications.  
 Higher manganese and silicone content assists in de-oxidising base materials.  
 Higher silicone content provides better wetting, flatter bead shapes and lower spatter than other grades of wire.  
 DC EP - DC current, electrode positive polarity  
 Copper Coated, precision layer wound.

**Recommended Gases: -**

80% Argon / 20% CO<sub>2</sub>  
 93% Argon / 5% CO<sub>2</sub> / 2% O<sub>2</sub>  
 100% CO<sub>2</sub>

**Classifications: -**

AS/NZS 14341:2012 - B G 49A 4U C1/M21 S6  
 AWS A5:18 ER70S-6

**Approvals: -**

Lloyds Register to Grade 3YS (Co2)  
 Lloyds Register to Grade 4YS (80% Argon/20%Co2)  
 American Bureau of Shipping to 4YSA  
 DB Systemtechnik Germany  
 Vd TUV

Typical Mechanical Properties	Welding Grade	Argon & 10-25
	CO <sub>2</sub>	CO <sub>2</sub>
Yield Stress	440 MPa	450 MPa
Tensile Strength	545 MPa	560 MPa
Elongation	28%	28%
CVN Impact	91J (-30°C)	87J (-20°C)

**Typical Chemical Composition (%): -**

C	0.07	Ti + Zr	0.019
Si	0.92		
Mn	1.55		
P	0.012		
S	0.012		
Ni	0.03		
Cr	0.04		
Mo	0.01		
V	0.01		
Cu	0.24		
Al	0.009		

**Suitable for all positional welding**



**Available Sizes: -**

Item	Desc	Dia	Spool
..111579	MER70S60805	0.8mm	5kg 200D
..111580	MER70S60905	0.9mm	5kg 200D
..111581	MER70S60815	0.8mm	15kg 300D
..111582	MER70S60915	0.9mm	15kg 300D
..111583	MER70S61215	1.2mm	15kg 300D

**WARNING**

Protect yourself and others. Read and understand this information. FUMES and GASES can be dangerous to your health. ARC RAYS can injure eyes and burn skin. Always wear correct personal protective equipment (PPE). Avoid inhalation of fumes. Assure there is adequate natural or exhaust ventilation at the point of welding/source of fumes. Never touch live electrical parts. ELECTRIC SHOCK CAN KILL. Before use, read and understand the relevant Material Safety Data Sheets (MSDS) or Safety Data Sheets (SDS) and your employers safety regulations and policies. For additional information regarding safety issues please refer to AS1674 and WTIA technical note TN07. Caution: be sure package is dry upon receipt. Store in a dry area above 10°C. First Aid - if exposed to excess welding fumes, remove to fresh air, in case of arc rays or electric shock employ normal first aid techniques and call a physician immediately.

**DO NOT COVER OR REMOVE THIS INFORMATION AND WARNING**

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