

WELD 70S-6

ESAB Weld 70S-6 is a copper-coated AWS ER70S-6 solid wire, suited for general purpose, manual and semiautomatic applications in most industries. It is manufactured under ESAB's Quality Control programs and meets AWS standards.

Specifications	
Classifications	EN ISO 14341-A : G 38 2 C1 Z 3Si1 SFA/AWS A5.18 : ER70S-6
Approvals	CWB : CSA W48-23
Industry	Industrial and General Fabrication Automotive Mobile Equipment Ship/Barge Building Civil Construction

Approvals are based on factory location. Please contact ESAB for more information.

Shielding Gas	M21, C1 (EN ISO 14175)
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Typical Weld Metal Analysis %				
C	Mn	Si	S	P
CO2(C1)				
0.07	1.5	0.9	0.010	0.013

Deposition Data						
Diameter	Current	Voltage	Wire Feed Speed	Deposition Type	Electrode Unit	Optimal Amps
0.9 mm (.035 in.)	180-230 A	25-27 V	1016-1397 cm/min (400-550 in./min)	Spray Transfer	206 m/kg (3670 in./min)	200 A
0.9 mm (.035 in.)	90-160 A	15-19 V	457-762 cm/min (180-300 in./min)	Short Arc Transfer	206 m/kg (3670 in./min)	130 A
1.2 mm (.045 in.)	130-200 A	17-19 V	318-508 cm/min (125-200 in./min)	Short Arc Transfer	124 m/kg (2220 in./min)	160 A
1.2 mm (.045 in.)	260-340 A	25-30 V	762-1270 cm/min (300-500 in./min)	Spray Transfer	124 m/kg (2220 in./min)	300 A