



MASTERWELD

The Welder's Ultimate Choice

AWS A5.18 ER70S-6
ASME SECT II PART C- 2017
SFA-5.18 R70S-6

MW70S-6

Mild Steel Welding Wire

Applications & Features

- MW70S-6 is a GMAW wire.
- It has a wide operation range, with a stable arc and low spatter.
- It is designed for welding in vehicles, shipbuilding, steel structures, bridges and pipes in single pass or multi-pass welding.

Welding Position:

All positions

Approvals:

ABS, BV, CR, NK



Typical chemical composition of weld metal (wt%) (Shielding Gas: 80%Ar + 20%CO₂)

C	Mn	Si	P	S
0.080	1.13	0.60	0.010	0.011

Typical mechanical properties of weld metal (Shielding Gas: 80%Ar + 20%CO₂)

Tensile Strength N/mm ² (MPa) (kgf/mm ²)	Yield Strength N/mm ² (MPa) (kgf/mm ²)	Elongation %	Charpy V-Notch	
			°C	J (kgf-m)
555(56.7)	431(44.0)	29	0	80(8.2)
			-30	69(7.1)

Size & recommended current range (DC+)

Diameter (mm)		0.8	0.9	1.0	1.2	1.4	1.6
Amp	F	50~180	50~200	50~220	80~350	100~470	200~500
	V-up	50~100	50~140	50~140	50~140	100~180	—
	OH	50~100	50~120	50~120	50~160	—	—
	V-down	50~100	50~200	—	—	—	—