

MW70S-6Z EnviroMIG

MW70S-6Z is uniquely designed with no copper coating to eliminate copper flaking and reduce copper fumes, and is manufactured under a quality system certified to ISO 9001 requirements.

Specifications: AWS A5.18 ER70S-6 ASME SECT II PART C - 2017 SFA-5.18 ER70S-6
 EN ISO 14341 - A G 42 4 C1/M21 3Si1

Applications & Features: Butt and fillet welding of sheet and plate of a variety of thickness, such as vehicles, building, ships, machinery and bridges in all positions.

Characteristics: Excellent feeding ability and arc-restart for robot welding especially, very consistent welding performance.

Notes on Usage: Good spatter control, low fume productions. Properly control the flow of shielding gas approx. 20 ~ 25l/min. Maintain outstretching length of wire between tip & base metal in the range of 15 ~ 20 mm.

Approvals: ABS, BV, CR, NK, CE

Typical chemical composition of weld metal (wt%)

| Shielding Gas | C | Mn | Si | P | S |
|--------------------------|------|------|------|-------|-------|
| 100% CO ₂ | 0.08 | 1.13 | 0.60 | 0.010 | 0.011 |
| Ar + 20% CO ₂ | 0.07 | 1.18 | 0.63 | 0.010 | 0.010 |

Typical mechanical properties of weld metal

| Shielding Gas | Tensile Strength N/mm ² | Yield Strength N/mm ² | Elongation % | Charpy V-Notch J (kgf•m) - 29°C |
|--------------------------|---------------------------------------|-------------------------------------|-----------------|------------------------------------|
| 100% CO ₂ | 555 | 441 | 29 | 69 (7.1) |
| Ar + 20% CO ₂ | 580 | 478 | 27 | 80 (8.2) |

Size available and recommended currents (DC+)

| Dia. mm | 0.8/0.9 | 1.0 | 1.2 | 1.4 | 1.6 | |
|---------|---------|--------|--------|--------|---------|---------|
| Current | F | 50~200 | 50~220 | 80~350 | 140~400 | 200~550 |
| Amp | V & OH | 50~120 | 50~150 | 50~160 | 100~250 | 120~280 |

