



## AUTOTHERME 70S-2

**CODIFICATION:** AWS : SFA 5.18 ER70S-2

### CHARACTERISTICS AND APPLICATIONS:

Autotherme 70S-2 is triple deoxidized copper coated mild steel wire for GMAW, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality welds. It is suitable for mild steel pipes. Ideal for welding A36, A285 Grade C, A515-55, A516-70, etc.

### TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	P	S	Ti	Zr	Al	Cu	Ni	Cr	Mo
%	0.05	1.25	0.55	0.02	0.02	0.10	0.09	0.09	0.06	0.10	0.10	0.10

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	YS (MPa)	Elongation (L = 4d) %	CVN Impact Strength At minus 30°C (Joules)
530	440	28.0	60

### WELDING PARAMETER : DC(+)

Diameter	Flat	
	Volt, V	Current, A
0.8 mm	28-32	170-200
1.2 mm	27-31	260-290
1.6 mm	26-30	330-360

**SHIELDING GAS:** Ar / CO<sub>2</sub>

**WELDING POSITION:** H, F, VU, OH

### PACKING:

STANDARD SIZE	Diameter 0.8 mm, 1.2 mm & 1.6 mm
QUANTITY	15.0 kg wire, random/ layer wound in a plastic spool that conforms to DIN-8559 SD-300.