

## F 70S-6

**CODIFICATION :**                      **AWS :**      SFA 5.18 ER70S-6

### **CHARACTERISTICS AND APPLICATIONS:**

F 70S-6 is a copper coated mild steel wire for GTAW. Suitable for welding of mild steel, low carbon steel and other structural steels of tensile strength up to 540 MPa. The wire burns with smooth arc. It is designed for welding of low and medium carbon steels like; SA-36, A/B/C/D grades of SA-283, A/B/C grades of SA-285, A/B grades of SA-414, etc.

### **TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:**

Element	C	Mn	Si	S	P	Cu
%	0.09	1.60	0.90	0.018	0.018	0.15

### **TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:**

UTS	YS	Elongation	CVN Impact Strength
(MPa)	(MPa)	(L = 4d) %	at minus 30°C (Joules)
510	440	26.0	45

**SHIELDING GAS:** Argon

**CURRENT CONDITION:** DCEN

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

**APPROVAL :** BV

### **PACKING :**

<b>STANDARD SIZE</b>	Diameter 1.6 mm, 2.0 mm, 2.4 mm & 3.2 mm in cut lengths of 500 mm / 1000 mm each.
<b>QUANTITY</b>	5 kg wire put in an air-tight polythene bag and finally packed in a plastic container. Identification AWS code is punched on each wire.