



DESCRIPTION

Executive 70S-6 CC is your best choice when consistency, reliability and exceptional value is required. It contains additional de-oxidizers that allow better wetting, flatter beads, faster travel speeds, and is the superior choice to other wire options such as 70S-3 in many applications.

Executive 70S-6 CC operates effectively with CO2 or Argon mixed gas and is optimized for welding steels with moderate amounts of scale or rust.

TYPICAL CHEMICAL VALUES

C	Cr	Ni	Mo	Mn	Si	P	V	S	Cu
0.08	0.03	0.02	0.01	1.5	0.85	0.01	0.005	0.01	0.03

TYPICAL WELDING PARAMETERS

DIAMETER, POLARITY, GAS	WIRE FEED SPEED M/MIN (IN/MIN)	VOLTAGE (VOLTS)	APPROX. CURRENT (AMPS)	SHIELDING GAS
.035" (0.9 mm), DC+				
Short Circuit Transfer	2.5 (100)	18	80	100% CO ₂ (Short circuit) Ar/CO ₂ Blends Ar/O ₂ Blends Tri-mixes
	3.8 (150)	19	120	
	6.4 (250)	22	175	
Spray Transfer	9.5 (375)	23	195	Ar/CO ₂ Blends Ar/O ₂ Blends Tri-mixes
	12.7 (500)	29	230	
	15.2 (600)	30	275	
.045" (1.1 mm), DC+				
Short Circuit Transfer	3.2 (125)	19	145	100 CO ₂ (Short circuit) Ar/CO ₂ Blends Ar/O ₂ Blends Tri-mixes
	3.8 (150)	20	165	
	5.1 (200)	21	200	
Spray Transfer	8.9 (350)	27	285	Ar/CO ₂ Blends Ar/O ₂ Blends Tri-mixes
	12.1 (475)	30	335	
	12.7 (500)	30	340	

TYPICAL MECHANICAL PROPERTIES

Tensile Strength:	75,400 PSI	520 MPA
Yield Strength:	66,700 PSI	460 MPA
Elongation:	30%	

CLASSIFICATION

Wire chemistry has been optimized for best performance and conforms to **AWS/SFA 5.18, Class ER70S-6**. It is certified for GMAW by the CWB to classification B-G 49A 3 C1 S6 (ER49S-6) of CSA Standard W48.