



exocor™

CARBON STEEL BARE WIRE DATA SHEET

executive 70S-6 CCX

DESCRIPTION

Executive 70S-6 CCX is a premium quality S6 designed for automated applications where elevated levels of consistency and reliability are demanded. It contains higher levels of Si and Mn 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.

As part of the executive family, Executive 70S-6 CCX is manufactured with tight tolerances that make it ideally suited for automatic and robotic applications. It is intended for both single and multi-pass welding.

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.