



exocor™

CARBON STEEL BARE WIRE DATA SHEET

executive 70S-6 CF

DESCRIPTION

Executive 70S-6 CF is the latest generation of carbon steel wire designed to reduce your overall welding costs. Whether you are operating in manual or robotic modes, this copper free wire will allow you to achieve new levels of performance by reducing overall welding costs.

Exocor's proprietary coating on the wire eliminates copper contamination of your feeding equipment and significantly prolongs the life of your contact tips, nozzles, gas diffusers, liners, and feed rolls. Low fume emission creates a healthier work environment for welders and shop personnel alike.

Each heat of Executive 70S-6 CF is certified to the current ASME standard and unique within the industry AS WELDED mechanical properties are provided as standard practice.

TYPICAL CHEMICAL VALUES

C	Cr	Ni	Mo	Mn	Si	P	V	S	Cu
0.06	0.05	0.03	0.01	1.5	0.85	0.01	0.01	0.01	0.07

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	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	Tri-mixes
	12.1 (475)	30	335	
	12.7 (500)	30	340	

TYPICAL MECHANICAL PROPERTIES AS WELDED

Tensile Strength:	83,000 PSI	570 MPA
Yield Strength:	77,000 PSI	530 MPA
Elongation:	27%	
Charpy V-Notch:	90 J (66 ft-lb) @ -29°C (-20°F)	
	80 J (59 ft-lb) @ -50°C (-58°F)	

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.