EXECUTIVE 70C-6 MC

CARBON STEEL

METAL CORED WIRE TECHNICAL DATA SHEET

DESCRIPTION

Executive 70C-6 MC is a high-quality and easy to use metal cored wire designed to help improve your productivity.

This premium wire is highly consistent with great weldability intended for single or multi-pass welding in a variety of steel weldments and fabrications.

The reduced fume emission adds to the great weldability by increasing arc visibility and improving air conditions in the shop.

Executive 70C-6 MC wire pulls silicon to the top of the weld where the silicon islands can be quickly removed which reduces your clean up time.

APPLICATIONS & FEATURES

Actual test certifications are provided with each heat / lot for both chemistry and mechanicals.

Typical applications include transportation and agricultural equipment manufacturing, structural fabrication, rail cars, storage vessels and shipping components.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Mn	Si	P	S	Cu	Ni	Cr	Mo	V
0.04	1.60	0.62	0.008	0.002	0.07	0.28	0.02	0.01	0.01

Tensile Strength:	82,800 PSI min	**Diffusible Hydrogen:**	2.4 ml / 100g	**Charpy Impact:**	120 ft-lb at -22°F (-30° C)
Yield Strength:	71,600 PSI min	**Elongation:**	32%		

TYPICAL WELDING PARAMETERS

Diameter	Voltage	Amperage	WFS (in/min)	Shielding Gas*
.045"	25	200	220	90% Ar / 10% CO_2
	27	300	440	
	30	375	760	
.052"	24	250	240	90% Ar / 10% CO_2
	30	400	550	
.062"	27	300	220	90% Ar / 10% CO_2
	32	400	330	

*If using a gas mixture with a higher percentage of CO_2, increase voltage listed by 1-3.

STANDARD PACKAGING

Spools	44-lb plastic spools		2,640-lb pallet	
Drums	.045"	440-lb	880-lb pallet	20" diameter
	.052"/.062"	660-lb	1,320-lb pallet	26" diameter

CLASSIFICATION

AWS A5.18 (2005)/ASME SFA A5.18 Class E70C-6M H4
AWS A5.36 (2016)/ASME SFA A5.36 Class E70C-6M H4
CWB CSA W48-18 E491T15-M20A4-CS1-H4 (E491C-6MJ-H4),
E491T15-M21A4-CS1-H4 (E491C-6MJ-H4)