

DESCRIPTION

Executive 70C-6 MC is a low fume premium quality metal cored wire intended for single or multi-pass welding in a variety of steel weldments and fabrications. This wire produces minimal silicon islands that are easily removed.

Certified test reports that include certification to AWS D1.8 for critical seismic applications with actual chemistry and mechanicals for 90% Ar / 10% CO₂ shielding gas is provided with each lot, which is unique in industry.

Compared to solid or flux cored wires like Executive 71 CM, Executive 70C-6 MC has higher deposition rates and faster travel speeds.

APPLICATIONS & FEATURES

Easy to use, with very smooth arc characteristics allowing for great operator appeal. Higher deposition rates compared to solid wire or flux cored in the flat position as well as superior gap bridging capabilities.

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 CO₂, increase voltage listed by 1-3.

STANDARD PACKAGING

Spools	44-lb plastic spools		2,640-lb pallet	
Drums	.045"	440-lb ea	880-lb pallet	20" diameter
	.052"/.062"	660-lb ea	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 E70T15-M20/M21A4-CSI-H4
 CWB E491T15-M20A4-CS1-H4 (E491C-6MJ-H4),
 E491T15-M21A4-CS1-H4 (E491C-6MJ-H4)

