

DESCRIPTION

EXECUTIVE 70S-2 with the addition of titanium, zirconium, and aluminum deoxidizers S2 wire is the optimal choice when welding through rust, dirt, and mill scale. While primarily used for single pass welding on deoxidized and partially deoxidized steels Executive 70S-2 is suitable for some multi-pass applications as well.

Executive 70S-2 is used to produce high quality, high toughness welds with the GTAW process. This filler metal is also well suited for use in single side, melt through welding without a protective root shielding gas on the backside of the joint.

APPLICATIONS & FEATURES

Typical applications include automotive, structural steel, carbon steel pipe, and plate.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Si	Mn	P	S	Cr	Mo	V	Ti	Cu	Zr	Al	Ni
0.04	0.50	1.10	0.01	0.01	0.15	0.15	0.03	0.1	0.50	0.05	0.1	0.15
Tensile Strength:		82,000 PSI min		Yield Strength:		68,000 PSI min		Elongation:		28%		

TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Speed (in/min)	Shielding Gas
GMAW - Short	.035"	18	80	100	Ar / CO ₂ Blends Ar / O ₂ Blends 100% CO ₂
		19	120	150	
		22	175	250	
	.045"	19	145	125	
		20	165	150	
		21	200	200	
- Spray	.035"	23	195	375	Ar / CO ₂ Blends Ar / O ₂ Blends
		29	230	500	
		30	275	600	
	.045"	27	285	350	
		30	335	475	
		30	340	500	
GTAW	.093" .125"	Direct Current; Electrode -		100% Ar	

STANDARD PACKAGING

GMAW (MIG)	33-lb wire baskets	1,980-lb pallet
GTAW (TIG)	10-lb plastic tube	40-lb carton

CLASSIFICATION

AWS/SFA 5.18, Class **ER70S-2**

