

DESCRIPTION

EXECUTIVE 70S-6 CC is your best choice in S6 wires for consistency, reliability and exceptional value. Executive 70S-6 CC is designed to exceed expectations by maintaining tight-tolerances within the AWS spec and ensuring that every heat/lot comes tested with actual chemistry and mechanicals.

Executive 70S-6 CC contains additional de-oxidizers 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.

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

APPLICATIONS & FEATURES

Executive 70S-6 CC operates smoothly with CO₂ or Argon mixed gas and is optimized for welding steels with moderate amounts of mill scale or rust. Uniform copper coating extends life of consumable MIG parts.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Si	Mn	P	S	V	Cu	Cr	Ni
0.08	0.85	1.50	0.01	0.01	0.005	0.03	0.03	0.02

Tensile Strength:	75,400 PSI min	Yield Strength:	66,700 PSI min	Elongation:	30%
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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"	Direct Current; Electrode -			100% Ar
	.125"				

STANDARD PACKAGING

GMAW (MIG)	44-lb wire baskets	2,640-lb pallet
	550-lb Drums	2,200-lb pallet
GTAW (TIG)	10-lb plastic tube	40-lb carton

CLASSIFICATION

AWS/SFA 5.18, Class ER70S-6 and CWB B-G 49A 3 C1 S6 (B-G 49A 3 C G6)

