

DESCRIPTION

EXECUTIVE 70S-6 CFP (Copper Free Plus) along with the great benefits of Executive Copper Free the *Plus* comes with actual mechanicals for every heat/lot tested to -50 Celsius to allow you to tackle extreme cold jobs with confidence.

Executive ER70S-6CFP leads the industry with immensely low spatter, incredibly little fume, and superior arc stability all culminating in excellent weldability.

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.

APPLICATIONS & FEATURES

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. Exceptionally low fume emission creates a cleaner and healthier work environment.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Si	Mn	P	S	
0.06	0.85	1.50	0.01	0.01	
Tensile Strength:	83,000 PSI min	Yield Strength:	77,000 PSI min	Elongation:	27%
Charpy V-Notch:	90 J (66 ft/lb) at -29°C / (-20°F)				
	80 J (59 ft/lb) at -50°C / (-58°F) *with 100% CO ₂				
	120 J (88 ft/lb) at -29°C / (-20°F)				
	106 J (78 ft/lb) at -50°C / (-58°F) *with 92/8 Ar*CO ₂				

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)

