

DESCRIPTION

Executive 70S-3 CC is a high quality, general purpose welding wire widely used for GMAW fabrication of mild steel material.

Executive 70S-3 CC is designed to be the ultimate in trouble free welding performance with smooth feedability and excellent arc stability. The weld puddle of this wire is more fluid than ER70S-2, producing better wetting characteristics and a flatter bead.

This wire is specially designed to reduce wear on consumables and produce great clean welds that require minimal clean-up. This is all to help improve arc on time to keep you welding.

APPLICATIONS & FEATURES

Typical applications include automotive, structural steel, carbon steel pipe, and plate. Suitable shielding gases for GMAW applications using ER70S-3 wires include Argon/CO₂, or Argon/O₂ with higher Argon content as well as 100% CO₂.

While designed for use on clean plate Executive 70S-3 CC has moderate levels of silicon and manganese deoxidizers will allow you to weld through light mill scale. This wire is also suitable for laser welding and WAAM applications (Wire Arc Additive Manufacturing, aka Metal 3D printing).

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Sn	Al	N
0.07	0.6	1.21	0.01	0.008	0.50	0.15	0.02	0.15	0.004	0.004	0.002	.005
Tensile Strength:		82,600 PSI min		Yield Strength:		69,500 PSI min		Elongation:		33%		
Charpy V-Notch:		145 ft/lb at 32°F / 0°C										
		129 ft/lb at -4°F / -20°C										

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	
- Spray	.035"	21	200	200	Ar / CO ₂ Blends Ar / O ₂ Blends
		23	195	375	
		29	230	500	
	.045"	30	275	600	
		27	285	350	
		30	335	475	
		30	340	500	

STANDARD PACKAGING

GMAW (MIG)	33/44-lb spools	1,980/2,640-lb pallet
	550-lb drums	2,200-lb pallet

CLASSIFICATION

AWS/SFA 5.18, Class ER70S-3

