

DESCRIPTION

EXECUTIVE 70S-6 CCX is a premium quality S6 designed for automated applications where elevated levels of consistency and reliability are demanded. Elevated Si and Mn levels allow better wetting-out, flatter beads, and faster travel speeds.

Executive ER70S-6CCX 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 CCX is certified to the current ASME standard and unique within the industry AS WELDED mechanical properties are provided as standard practice.

APPLICATIONS & FEATURES

As part of the executive family, Executive 70S-6 CCX is manufactured with tight tolerances that make it ideally suited for automatic and robotic applications. It is intended for both single and multi-pass welding

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Si	Mn	P	S
0.08	0.85	1.50	0.01	0.01

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	
		19	145	125	
		20	165	150	
	.045"	21	200	200	
		23	195	375	Ar / CO ₂ Blends Ar / O ₂ Blends
		29	230	500	
		30	275	600	
		27	285	350	
- Spray	.035"	30	335	475	Ar / CO ₂ Blends Ar / O ₂ Blends
		30	340	500	
GTAW	.093"	Direct Current; Electrode -			100% Ar
	.125"				

STANDARD PACKAGING

GMAW (MIG)	44-lb Spools, 550-lb Drums	2,640-lb pallet 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)

