

DESCRIPTION

Executive 70S-6 CF (Copper Free) is the latest generation of carbon steel wire designed to increase total productivity while reducing your total welding costs. Executive Copper Free 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. Executive 70S-6 CF 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.

This wire is also suitable for laser welding and WAAM applications (Wire Arc Additive Manufacturing, aka Metal 3D printing).

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)				

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	

STANDARD PACKAGING

GMAW (MIG)	44-lb wire baskets	2,640-lb pallet
	550-lb Drums	2,200-lb pallet

CLASSIFICATION

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

