

#### 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 70S-6 CFP 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 CFP 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		
<b>Tensile Strength:</b>		83,000 PSI min	<b>Yield Strength:</b>		77,000 PSI min	<b>Elongation:</b> 27%
<b>Charpy V-Notch:</b>		90 J (66 ft/lb) at -29°C / (-20°F)				
		80 J (59 ft/lb) at -50°C / (-58°F) *with 100% CO <sub>2</sub>				
		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 <sub>2</sub>				

#### TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Speed (in/min)	Shielding Gas
GMAW - Short	.035"	18	80	100	
		19	120	150	
		22	175	250	Ar / CO <sub>2</sub> Blends
	.045"	19	145	125	Ar / O <sub>2</sub> Blends
		20	165	150	100% CO <sub>2</sub>
- Spray	.035"	21	200	200	
		23	195	375	
		29	230	500	
	.045"	30	275	600	Ar / CO <sub>2</sub> Blends
		27	285	350	Ar / O <sub>2</sub> Blends
		30	335	475	
		30	340	500	

#### STANDARD PACKAGING

<b>GMAW (MIG)</b>	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)

