



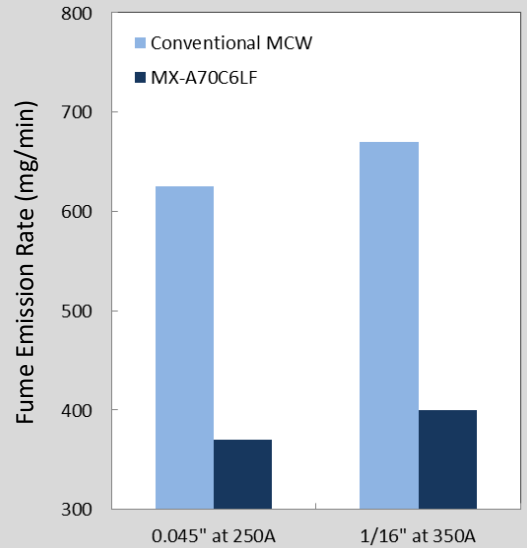
Mild Steel Metal Cored Wire

AWS A5.18 E70C-6M

CWB CSA W48-18 E491C-6M-H4

Features and typical fields of application

- MX-A70C6LF is a 70ksi class mild steel metal cored wire for flat and horizontal welding with 75-95%Ar-bal. CO₂ mixed gas.
- Its low fume emission, minimized spatter generation formula creates a clean welding environment at any welding condition.
- This wire is specifically developed to produce high deposition rates suitable for heavy industrial applications over conventional solid wire.



Typical mechanical property of weld metal per AWS A5.18

Shielding Gas	0.2% PS (ksi)	TS (ksi)	El (%)	CVN at -20°F (ft-lbs)
80%Ar-20%CO ₂	65	80	34	96
95%Ar-5%CO ₂	67	82	34	101

Typical chemical composition of weld metal per AWS A5.18

Shielding Gas	C	Si	Mn	P	S	Diffusible Hydrogen Content* (mL/100g)
80%Ar-20%CO ₂	0.04	0.79	1.62	0.008	0.009	2.9
95%Ar-5%CO ₂	0.04	0.85	1.69	0.007	0.010	3.5

*: Gas chromatography method (AWS A4.3)

Approvals

CWB



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Recommended welding conditions and deposition rate

Wire Dia.	Wire Feed Speed (in/min)	Current (A)	Arc Voltage (V)	Deposition Rate (lbs/hr)	Wire Stick-Out	Shielding Gas flow rate (CFH)
0.045"	130	120	21-24	3.4	3/4-1"	40-50
	210	160	23-26	5.4		
	290	200	25-28	7.4		
	330	220	25-28	8.4		
	410	260	26-29	10.4		
0.052"	110	140	22-25	3.6	3/4"	40-50
	170	180	22-25	5.8	1"	
	260	240	24-26	9.1		
	290	260	25-27	10.2		
	360	300	27-29	12.4		
1/16"	90	200	22-25	3.6	3/4"	40-50
	140	240	23-26	9.4	1"	
	170	260	24-27	10.4		
	220	300	27-29	12.4		
	280	340	28-30	14.4		

Table shown are approximate values that will vary depending on welding conditions (WESO, Cable length etc.).

Available Products

Wire Dia.	0.045", 0.052", 1/16"	Package	44 lbs spool , 550 lbs drum
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DISCLAIMER

- Information in this material, such as chemical compositions and mechanical properties, is typical or an example for explaining the features and performances of our products, and it does not mean guarantee unless otherwise it is specified.
- Information contained herein is subject to change without notice. Please kindly contact Kobelco for latest information.



WARNING: This product can expose you to chemicals including Nickel and Titanium Dioxide, which are known to the State of California to cause cancer, and Chromium, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to www.P65Warnings.ca.gov.

KOBELCO WELDING OF AMERICA INC.

