

AUTOMIG 70S-6

COPPER COATED C-Mn STEEL GMAW FILLER WIRE FOR 500 MPA TENSILE STRENGTH STEEL



CE

CLASSIFICATION : EN ISO 14341-A

AWS A/SFA 5.18

APPROVALS:

G 42 3 C G3Si1

ER70S-6

ABS/BV/DNV/IRS/IBR/LRA/NPCIL

G 42 3 M G3Si1

MND/RDSO/BHEL/CE

KEY FEATURES :

- C-Mn steel solid wire
- Uniform copper coating
- Smooth wire feeding
- Can be use with 100% CO₂ Ar+CO₂
- Higher level of de-oxidizers makes it suitable for applications where dirt, rust or mill-scale is present
- Radiographic quality weld

WELDING POSITION :



DCEP

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
Co ₂	12-18	10-20
80Ar+20CO ₂	17-22	10-20

TYPICAL APPLICATIONS :

- Construction and mining equipment
- Pressure vessels, LPG Cylinders
- Root pass pipe welding, Tanks, Structural steel components
- Railcar construction and repair, Frame fabrication
- Thin sheet metal, Auto body
- Farm implements, Steel casings
- High-speed robotic, automatic and semi-automatic welding applications
- Shaft build up, General fabrication

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STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :

	C	Mn	Si	S	P	Cu*
Specification	0.06-0.14	1.40-1.60	0.80-1.0	0.025 max	0.025 max	0.35 max

* Including Cu in the coating

MECHANICAL PROPERTIES OF ALL WELD METAL :

Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -30°C, J	
Specification	As Welded	500-640	420 min	22 min	47 min

Hardness, 3 Layer: 200 BHN max (irrespective of type of gas used) With mixed gas mechanical properties will be higher.

PARAMETERS - PACKING DATA :

Ø, mm	Voltage, V	Amperage, A	Kg/Spool	MIGPAC DRUM, Kg
0.8	18 – 26	100 – 200	15	100 / 250
1.0	18 – 30	150 - 300	15	100 / 250
1.2	20 – 32	200 – 350	15	100 / 250
1.6	24 – 35	275 – 450	15	100 / 250

Also sold as Automig 1

EQUIVALENT :

SMAW Electrode: Supabase X Plus



ADOR WELDING LIMITED

Regd. & Corp. Office: Ador House, 6, K. Dubash Marg, Fort, Mumbai 400 001. INDIA | CIN: L70100MH1951PLC008647
 Tel: +91 22 6623 9300 / 2284 2525 | Fax: +91 22 2287 3083 / 2596 6562 | Email: cmo@adorians.com | Web: www.adorwelding.com

