MILD STEEL WIRE

Specifications
AWS A5.18 Class ER70S-6

Certified by CWB
to CSA W48-Class ER49S-6

Description

S6 contains high levels of manganese and silicon for stronger deoxidizing power where stringent cleaning procedures are not possible. This wire has been designed to provide X-ray quality porosity-free welds and the highest tensile strength (as welded) of the plain carbon steel wires. The high silicon content increases the fluidity of the weld pool, creating a smoother bead appearance and resulting in minimal post-weld grinding. S6 is excellent where poor fit-ups or rusty and oily plates may be used.

Applications

Construction work, tanks, truck bodies, farm implements, pipes, steel castings or forgings, shaft build-ups and general shop fabrications.

DIAMETER	SPOOL SIZES				
	1KG (2.2LB)	5KG (11LB)	15KG (33LB)	20KG (44LB)	250KG (550LB)
0.6mm (.023")	S6061	S6065	S60615		
0.8mm (.030")	S6081	S6085		S60820	
0.9mm (.035")	S6091	S6095		S60920	S609250
1.2mm (.045")	S6121	S6125		S61220	S612250

1kg spools are packaged 18 spools per master carton.
20kg spools are packaged 60 spools (1200kg) per pallet.
250kg drums are packaged 2 drums (500kg) per pallet.

Typical chemical composition of welding wire (%)	C	Mn	Si	P	S	Cr	Ni	C
	0.06-0.15	1.40-1.85	0.80-1.15	≤ 0.025	≤ 0.035	-	-	≤ 0.050
Mechanical Properties of Deposited Metal	Yield strength (Mpa)		Tensile strength (Mpa)		Elongation (%)		AKV impact (J)	
	≥ 420		≥ 500		≥ 22		≥ 27@-29°	
Wire Size (mm)	0.8	0.9	1.2	1.6	Welding Positions			
Recommended Welding Current (A)	40 - 140	50 - 220	80 - 350	120 - 550				