

Standard: AWS A5.18 ER70S-G	Chemical Composition %					
	C	Mn	Si	Ti	S	P
Company Standard	0.07~0.10	1.51~1.80	0.65~1.00	0.15~0.20	≤0.035	≤0.035
	Actually: As agreed between supplier and purchaser ( Normal ER70S-6 + Ti )					
Type	Spool (MIG)			Tube (TIG)		
Specification (MM)	0.8、0.9、1.0、1.2、1.6、2.0			1.6、2.0、2.4、3.2、4.0、5.0		
Package	S100 / 1kg S270,S300 / 15kg-20kg		S200 / 5kg	5kg / box	10kg / box	length :1000MM
Mechanical Properties	Tensile Strength Mpa	Yield Strength Mpa		A (%)	KV2 (J) -30℃	
	≥ 480	≥ 400		As agreed between supplier and purchaser		
	Diameter (MM)	0.8	1.0	1.2	1.6	
MIG Welding	Welding Current A	50 – 100	50 – 220	80 – 350	170 – 550	
	CO2Gas-flow L/min	15	15 – 20	15 – 25	20 – 25	
Performance characteristics	<p>The addition of trace Ti element ER70S-G on the basis of ER70S-6 can help to reduce the spatter in CO2 gas shielded welding.</p> <p>By optimizing the chemical composition of the welding wire, the welding spatter and the weld forming can be matched properly.</p>					
Application	1、Welding of various 500 N / mm2 tensile strength grade structural steel components.					
Notice	<p>1、The product can be kept for two years under the condition of factory packing and sealed, and the packing can be removed for three months under the usual atmospheric environment.</p> <p>2、Products should be stored in a ventilated, dry and place.</p> <p>3、After the wire is removed from the package, it is recommended that appropriate dust proof cover be applied over the wire.</p>					