



# WELD 70S-6

ESAB Weld 70S-6 is a copper-coated AWS ER70S-6 solid wire, suited for general purpose, manual and semiautomatic applications in most industries. It is manufactured under ESAB's Quality Control programs and meets AWS standards.

## Process

- GMAW (MIG/MAG)

## Specifications

Classifications	EN ISO 14341-A : G 38 2 C1 Z 3Si1 SFA/AWS A5.18 : ER70S-6 JIS : YGW 12
Approvals	ABS : 3YSA (M21 & C1) CWB : CSA W48-18 JIS : YGW12 LR : 3Y H15 (M21 & C1)
Industry	Ship/Barge Building Civil Construction Mobile Equipment Industrial and General Fabrication Automotive

Approvals are based on factory location. Please contact ESAB for more information.

### Typical Weld Metal Analysis %

C	Si	Mn	P	S
<b>CO2(C1)</b>				
0.07 %	0.9 %	1.5 %	0.013 %	0.010 %

### Deposition Data

Diameter	Current	Wire Feed Speed	Voltage	Optimal Amps	Deposition Type	Electrode Unit
0.9 mm (.035 in.)	180-230 A	1016-1397 cm/min (400-550 in./min)	25-27 V	200 A	Spray Transfer	206 m/kg (3670 in./min)

0.9 mm ( .035 in. )	90-160 A	457-762 cm/min ( 180-300 in./min )	15-19 V	130 A	Short Arc Transfer	206 m/kg ( 3670 in./min )
1.2 mm ( .045 in. )	130-200 A	318-508 cm/min ( 125-200 in./min )	17-19 V	160 A	Short Arc Transfer	124 m/kg ( 2220 in./min )
1.2 mm ( .045 in. )	260-340 A	762-1270 cm /min ( 300-500 in./min )	25-30 V	300 A	Spray Transfer	124 m/kg ( 2220 in./min )