

AK E70C-6M

Description: Metal cored wire for carbon steel application. Excellent impact toughness properties down to -60F.

Application: For carbon steel applications using mixed gas 75-95% Argon (Ar)/ balance Carbon Dioxide(CO₂), Non-alloyed and fine grain steels、Single or multipass welds、Automated and mechanized welding、Offshore 、Pipeline 、 Pressure vessels 、 Heavy equipment 、 Structural fabrication 、 Industrial machinery.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Cr	Mo	
Requirement	0.12	0.90	1.75	0.03	0.04	0.50	0.20	0.30	—
Actual Result	0.052	0.53	1.36	0.012	0.011	0.023	0.064	0.001	—

Typical Mechanical Properties:

	Tensile Strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact values (J)
Requirement	≥480	≥400	≥22	≥27(-30℃)
Actual Result	544	494	27	121

Recommended welding parameters:

Diameter/ mm	1.2	1.6		
Welding voltage/V	20-30	20-30	—	—
Welding current/A	140-250	160-260	—	—