

AK ER70S-4

Description: AK-ER70S-4 is a CO₂ gas shielded welding wire with H11MnSi disc element and copper-plated surface. The welding wire can be used as shielding gas with CO₂ or Ar+CO₂5%-20%, and the welding process performance is good. Under the small current specification, vertical down welding can be carried out, and the weld strength may be improved when shielded with mixed gas.

Application: It is suitable for welding carbon steel, and may also be used for high-speed welding of thin plates and pipes.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Cr	Mo	Cu
Requirement	0.06-0.15	0.65-0.85	1.0-1.5	0.025	0.025	0.15	0.15	0.15	0.50
Actual Result	0.078	0.72	1.15	0.012	0.015	0.02	0.02	0.02	0.12

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥ 500	≥420	≥ 22	— —
Actual Result	590	480	29	91J(-30℃)