

AK ER70S-6

Description: A gas shield copper-coated carbon steel welding wire for fabrication of mild steel. It provides excellent usability with stable arc, less spatter, good bead appearance. The weld metal has excellent mechanical performance and is less sensitive to pores.

Application: Used for carbon steel and alloy steel with 500MPa tensile strength structures welding, and high speed welding of sheet plates and pipelines.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Cr	Mo	Cu
Requirement	0.06-0.15	0.8-1.15	1.4-1.85	0.025	0.025	0.15	0.15	0.15	0.50
Actual Result	0.08	0.92	1.67	0.008	0.010	0.02	0.01	0.01	0.07

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥ 500	≥420	≥ 22	≥27J(-30℃)
Actual Result	560	470	26	68

Recommended welding parameters:

Diameter/ mm		0.8	1.0	1.2
Welding current/A	Flatwelding	50-200	80-250	100-360
	vertical welding	50-140	80-160	80-220