



## CERTIFICATION OF COMPLIANCE



### TECHNIWELD

Alloy ER70S-6

AWS/ASME SF A5.18

All Position

### FILLER METAL TYPE:

MILD STEEL

### SHIELDING GAS:

100% CO<sub>2</sub>

ARGON-BASED MIX (MIG ONLY)

### DESCRIPTION AND APPLICATIONS:

ER70S-6 is a copper-based solid wire containing high levels of manganese and silicon. ER70S6 is suitable for many carbon steel welding applications using the Mig Gas Metal Arc Welding (GMAW) process. The high levels of deoxidizers in ER70S6 provide excellent tolerance of rust and mill scale, the high levels of manganese and Silicon also provide excellent wetting action and a highly fluid weld puddle. Shielding gas choices for ER70S6 in the GMAW mode are 100% Carbon Dioxide, Argon/Carbon Dioxide mixtures, Argon/Oxygen mixtures, and other Argon based mixed gas blends. ER70S6 excels in HVAC duct work, heavy equipment fabrication, structural, and other general fabrications.

#### Chemical Composition of ER70S-6

C	Mn	Si	P	S	Ni	Cr	Mo	V	Cu	Ti	Zr	Al
0.06-0.15	1.40-1.85	0.80-1.15	0.025	0.035	0.15	0.15	0.15	0.03	0.50	--	--	--

Single values are maximum unless otherwise specified.

(As Welded)

Shielding Gas:		CO <sub>2</sub>
Tensile Strength (min)	psi:	70,000
	MPa:	480
Yield Strength (min)	psi:	58,000
	MPa:	400
Elongation % (min)		22

THIS IS TO CERTIFY THAT THE PRODUCT IDENTIFIED ON THIS CERTIFICATE OF COMPLIANCE SUPPLIED, IS APPROVED TO AND OR CONFORMS TO THE REQUIREMENTS OF THE CLASSIFICATION (S) STATED HEREIN. ALL TESTING REQUIRED BY SPECIFICATION (S) WERE PERFORMED ACCORDING TO SPECIFIED PROCEDURES.

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