



AUTOMIG 70S-G

AWS A/SFA 5.18 ER70S-G

GMAW C-Mn Steel

CLASSIFICATION:

EN ISO 14341-A

G 46 4 C1 4Si1

G 50 5 M21 4Si1

IS 6419

S4-C/M 504

KEY FEATURES:

- C-Mn steel GMAW solid wire
- Uniform copper coating
- Smooth wire feeding
- Can be use with 100% CO₂, Ar+CO₂
- All Position Welding capability
- Suitable for applications where dirt, rust or mill-scale is present
- Radiographic quality weld

APPROVALS: CE

TYPICAL APPLICATIONS:

- Pressure vessels, LPG Cylinders
- Construction and mining equipment
- Pipe and Structural steel welding
- Thin sheet metal, Auto body
- General fabrication
- Farm implements, Steel casings
- High-speed robotic, automatic and semi-automatic welding applications

TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:


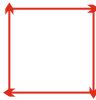
C	Mn	Si
0.07	1.65	0.85

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	Shielding Gas	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -50°C, J
Typical	As Welded	100% CO ₂	600	490	27	60
Typical	As Welded	80Ar + 20CO ₂	615	500	28	70

Hardness, 3 Layer: 210 BHN max

PARAMETERS - PACKING DATA:

Ø, mm	Wt / Spool, kg		
0.8	15	 DCEP STORAGE / HANDLING : Keep dry and follow handling instructions mentioned on the box	All Positions 
1.0	15		
1.2	15		
1.6	15		

Shielding Gas	Gas Flow Rate, LPM
CO ₂	12-18
80Ar+20CO ₂	17-22