



AUTOMIG MC 70C-6C

AWS A/SFA 5.18 E70C-6C-H4

MCAW C-Mn STEEL

CLASSIFICATION:

EN ISO 17632-A
T 42 3 M C1 3 H5

KEY FEATURES:

- Metal cored wire suitable with CO2 shielding gas
- Good weldability, minimal or no slag
- Excellent bead appearance
- Exceptional mechanical properties at low temperatures
- High deposition rate
- Suitable for single and multi pass welding
- Best suited for automated and robotized applications

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of Carbon, C-Mn and similar types including fine grained steels
- Ship building, Boilers
- Suitable for joining SA 36/36M (P.No.1), SA 285/285M Gr.A/B/C (P.No.1)
- Pressure Vessels, Pipe steels

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:



C	Mn	Si
0.06	1.4	0.45

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -30°C, J
Typical	As Welded	580	480	26	60

Diffusible H2 Content: <4 ml/100 gm

PARAMETERS - PACKING DATA:

∅, mm	Net Wt, Kg	
1.2	15	 DCEP
1.6	15	
		Flat butt and fillet welds only 
STORAGE / HANDLING : Keep dry and follow handling instructions mentioned on the box		

Shielding Gas	Gas Flow Rate, LPM
100% CO ₂	15-20