



# AUTOMIG MC 70C-6M

AWS A/SFA 5.18 E70C-6MH4

MCAW C-Mn STEEL

### CLASSIFICATION:

EN ISO 17632-A  
T 46 4 M M21 3 H5

### KEY FEATURES:

- Metal cored wire suitable with Ar-CO<sub>2</sub> 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, Boiler
- 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	1.45	0.4

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -40°C, J
Typical	As Welded	585	490	28	60

Diffusible H<sub>2</sub> Content: <4 ml/100 gm

### PARAMETERS - PACKING DATA:

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

Shielding Gas	Gas Flow Rate, LPM
80Ar+20CO <sub>2</sub>	15-20