



Code & Specification

ASME SFA/AWS A5.18 ER70S-6

Description

BLUME[®] ER70S-6 is a general purpose welding wire for fabrication of mild steel . It is well suited for general purpose, manual and semiautomatic applications in most industries. Contains deoxidizers that provide better wetting, yielding a flatter bead shape and the capability of faster travel speeds . Usually used with 100% CO₂ or with Argon + CO₂.

Applications

BLUME[®] ER70S-6 is a wire with higher levels of Deoxidizers (Mn & Si) compared to other carbon steel wires. This wire is suitable for welding of steels with moderate amounts of scale or rust.

Shielding Gas

100% CO₂ , 75% Argon and 25% CO₂ or 98% Argon and 2 % CO₂

Mechanical Properties

	As-welded
Yield Point, MPa	≥ 420
Tensile Strength, MPa	≥ 500
Elongation, %(L=4d)	≥ 29

Charpy V-Notch Impact Properties

Testing Temp.	As-welded (J)
-30°C (-22°F)	47 (min)

Undiluted Weld Metal Analysis (wt%)

C	Mn	Si	S	P~
0.06 - 0.15	1.40 - 1.85	0.80 - 1.15	≤ 0.025	≤ 0.025
Cu	Ni	Cr	Mo	V
≤ 0.05	≤ 0.15	≤ 0.15	≤ 0.15	≤ 0.03

Suggested Welding Parameters (DC+)

Diameter	Flat		Vertical-up		Overhead	
	Volts	Amps	Volts	Amps	Volts	Amps
1.2mm (.045")	20 - 32	80 - 350	18 - 20	120 - 160	18 - 20	120 - 160
1.6mm (1/16")	32 - 38	350 - 500	18 - 22	120 - 220	18 - 22	110 - 210

Packaging

15 kgs (33 lbs) [Net Weight] Plastic spools with OD = 270mm (11")

Approvals



Blumenotics Pvt. Limited

An ISO 9001:2015 Company

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