

SUNMIG 70S-6

Copper Coated CO₂ Wire



CLASSIFICATION

AWS A 5.28 : ER70S-6
IS 6419-1996 : GRADE S4-504
Approval : THERMAX

CHARACTERISTICS

SUNMIG S-6 is a double deoxidized copper coated Mn-Si wire suited for Gas Metal Arc Welding in all position for mild and fine grained steels. Produce weld with excellent radiographic qualities. Thin and uniform copper coating ensures good electrical contact, reduces friction during high speed feeding and obviates corrosion possibilities.

APPLICATIONS

SUNMIG S-6 is suitable for welding of Sheet-Metal, Carbon Steel and Low Alloy Steels. Also find its applications in Construction and mining equipments, Auto Body, Pressure Vessels, LPG Cylinders, Farm Equipments, Steel Casings, Tanks, Structural steel components and High speed robotic/automatic/semi-automatic welding applications.

CHEMICAL COMPOSITION OF BARE SOLID WIRE (TYPICAL) (%):

Carbon	Manganese	Silicon	Copper	Sulphur	Phosphorus
0.09	1.48	0.82	0.25	0.017	0.018

MECHANICAL PROPERTIES OF ALL WELD METAL (TYPICAL):

Yield Strength (N/mm ²)	Ultimate Tensile Strength (N/mm ²)	Elongation (%) GL=5d	Reduction in Area (%)	CVN Impact at -30°C (Joules)
484.0	592.0 N/mm ²	23.41%	58.4%	54 Joules avg/ 130 Joules avg

PACKING DATA:

Diameter (mm)	Voltage (Volts)	Current (DC+)(Amp)	KG/spool
0.80	18-26	100-200	15 Kg
1.00	18-30	140-240	15 Kg
1.20	20-32	180-260	15 Kg
1.60	24-35	200-320	15 Kg

SHIELDING GAS : 100% CO₂ or 80% Argon-20% CO₂