



MIG 70S-6

MAARS
Weld Company Limited

COPPER COATED C-Mn STEEL GMAW FILLER WIRE FOR 500 MPA
TENSILE STRENGTH STEEL

CLASSIFICATION:

EN ISO 14341-A

AWS A/SFA 5.18

APPROVALS

G 42 3 CG3SiI

G 46 3 MG3SiI

ER70S-6

CE/IBR/ABS/ASHOK

LEYLAND

KEY FEATURES:

- Copper coated low alloy steel
- All Position Welding
- The Wire has a very good welding performance
- Can be use with 100% CO₂, Ar+CO₂
- Higher level of de-oxidizers
- Ships, containers, vehicles, engineering machinery construction equipment, mining equipment,
- All Welding in steel fabrication.

WELDING POSITION:



DCEP

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
CO ₂	12-18	10-20
80Ar+20CO ₂	17-22	10-20

TYPICAL APPLICATIONS:

- Automobile Body, Chasis, Frames.
- The wire has smooth wire feeding
- LPG Gas Cylinders, Compressor, Railway Wagons, Boiler Components
- Poles & Steel Towers, Steel Furniture, Scaffolding, Gratings.
- Thin sheet metal, Auto body, Ships, Containers, vehicles.
- High-speed robotic, automatic, and semi-automatic welding applications.
- Engineering machinery construction equipment, mining equipment, railway wagons and coaches, pipes and bridges

STORAGE/HANDLING:

Keep dry and follow handling instructions mentioned on the box

CHEMICAL COMPOSITION OF UNDILUTE WELD METAL:

	C	Mn	Si	S	P	Cu*
Specification	0.06 – 0.15	1.40 – 1.85	0.80 – 1.15	0.035	0.025	0.50
Typical Value	0.08	1.15	0.85	0.025	0.025	0.20

*Including Cu in coating

MECHANICAL PROPERTIES OF ALL WELD METAL:

Condition		Shielding Gas	UTS, Mpa	YS at 0.2 % offset, Mpa	EL%	CVN Impact at -30°C, J
Specification	As Welded	100% CO ₂	480	400 min	22 min	27 J min

Hardness, 3 layers: 200 BHN max (irrespective of type of gas used) with mixed gas mechanical properties will be higher

PARAMETERS – PACKING DATA:

Ø, mm	Voltage, V	Amperage, A	Kg/Spool	MIGPAC DRUM, Kg
0.8	17-27	80-250	15/18	100/250
1	18-30	100-350	15/18	100/250
1.2	20-34	120-400	15/18	100/250
1.6	24-36	150-450	15/18	100/250

Also sold as JACKSUN ER70S-6