

ER 70S-6 (A18)

Mild Steel TIG/GTAW

Standards

EN/ISO-Standard - 636-A

AWS-Standard - A5.18

EN/ISO-Classification - W 42 4 3Si1

AWS-Classification - ER 70S-6

Features and Applications

- A copper coated wire containing high levels of manganese and silicon for stronger deoxidizing power where stringent cleaning procedures are not possible.
- The high silicon content increases the fluidity of the weld pool, creating a smoother bead appearance and resulting in minimal post-weld grinding.
- Good mechanical properties at sub-zero temperatures down to -40°C.
- Typically used on boilers, industrial machinery, bridges, shipbuilding, automotive, rail, structural and engineering fabrications etc.
- Green wire is produced using virgin raw materials sourced from specialised steel mills, which ensures consistent reliability and quality.
- **Test Certificates can be found online @wilkinsonstar247.com**



Typical Base Materials

S185, S235, S275, S355 - Grade A, B, D, AH32 to DH36 - L210, L240, L290, L360, L240NB, L290NB, L360NB, L360QB, L240MB, L290MB, L360MB, L415MB - X42, X46, X52, X60 - P235T1, P235T2, P275T1 - P275T2, P355N - P235GH, P265GH, P295GH, P355GH - S275, S355, S420, S275M, S275ML, S355M, S355ML, S420M, S420ML*

* Illustrative, not exhaustive list

Welding Positions

EN ISO 6947 - PA, PB, PC, PD, PE, PF

Shielding Gases

EN ISO 14175 - TIG: I1 (Argon)

Polarity

TIG DC (-)

Chemical Composition of Weld Metal % (Typical)

C %	Si %	Mn %	P %	S %	Cu % ^a	Cr %	Ni %	Mo %	Al %	V %	Zr + Ti %
0.07	0.85	1.45	<0.020	<0.020	<0.25	<0.15	<0.15	<0.050	<0.020	<0.030	<0.15

^a (includes copper coating)

Packaging Data

Part No.	Diameter Ø (mm)	Package Length (mm)	Package Weight (Kg)	Package Type
3010300154	1.00	1000	5	Cardboard Tube
3010300155	1.20	1000	5	Cardboard Tube
3010300156	1.60	1000	5	Cardboard Tube
3010300158	2.40	1000	5	Cardboard Tube
3010300159	3.20	1000	5	Cardboard Tube

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