

# AUTOMIG 70S-6 (AUTOMIG 1)

## Classification

AWSA/SFA 5.18 : ER 70S-6  
 AWSA/SFA 5.18M : ER48S-6  
 IS 6419 : S4-C 504

## Approvals

TOYO ER 70S-6 ABS Gr - 3Y 5A DCL  
 RDSO CI 1 BV Gr - SA 3YM  
 IBR ER 70S-6 DNV Gr - 3YMS  
 BHEL ER 70S-6 IRS Gr - 3S,3YS  
 MND LRS - DxVuo, BF, 3YS H15,NA  
 GL 3YS SONCAP

## Characteristics

A copper coated MIG wire for MIG/MAG welding of Carbon steels. Uniform copper coating smooth feeding, stable arc and minimum spatter under optimum welding conditions. Normally recommended with CO<sub>2</sub> shielding, but can be used with Ar-CO<sub>2</sub> mixtures also. The higher content of deoxidizers makes this wire suitable for applications where dirt, rust or mill-scale is present.

## Typical Applications

Wide applications in automotive industry, construction and mining equipment, railway wagons and coaches, etc. Also suitable for welding pipe, pressure vessels, LPG cylinders, pre-engineered buildings and structural steel components.

## Wire Chemistry

C	Mn	Si	S	P	Cu
0.07-0.14	1.40-1.60	0.80-1.00	0.025 max	0.025 max	0.50 max

Shielding Gas CO<sub>2</sub> Current Condition: DC (+)

## All Weld Mechanical Properties As welded condition

Shielding Gas	UTS	YS	Elongation	RA	CVN Impact, J	
	MPa	MPa	% (L=4×d)	%	-20°C	-30°C
100% CO <sub>2</sub>	490-550	400-480	22 min	45 min	50-80	30-50
80/20 Ar-CO <sub>2</sub>	550-600	480-520	24 min	50 min	60-90	80-120

The chemistry and mechanical properties of the weld metal will vary with the type of shielding gas used.

Welding Position: F, H, V-up, V-down,

## Packing Data

Dia (mm)	0.8	0.9	1.0	1.2	1.6
Plastic Spools Net wt-kg	15	15	15	15	15



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