

SM-70EN

Classification

AWS A5.18/ ASME SFA-5.18 ER70S-6
JIS Z 3312 YGW12
EN ISO 14341-A G 42 2 C1 4Si1 / ISO 14341-A G 46 5
M21 4Si1

Features

- All position welding by short-circuiting type transfer
- Mixed gas
- Good Bead Appearance and low spatter

Application Areas

- Structural fabrication
- Automotive
- Machinery

Approvals

DNV	CE	DB	TUV
✓	✓	✓	✓

Typical Chemical Composition of the Wire (wt%)

C	Si	Mn	P	S
0.08	0.95	1.65	0.019	0.015

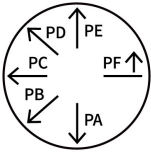
Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft · lbs)
100% CO2	460 (67)	560 (81)	29	-20 (0)	95 (70)
				-30 (-20)	55 (41)
Ar + 20% CO2	520 (75)	620 (90)	27	-20 (0)	110 (81)
				-50 (-60)	70 (52)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Packaging
0.9 (0.035), 1.0 (0.039), 1.2 (0.045), 1.4 (0.052), 1.6 (1/16)	Spool 15kg(33lbs), 20kg (44lbs) Drum 250kg (551lbs), 300kg (661lbs), 350kg (771lbs)

Welding Positions



Polarity

DC +

Shielding Gas

100% CO2
Ar + 20% CO2

SMW

GMW

GTAW

FCW

Metal-cored Wire

SAW Wire

SAW Flux