

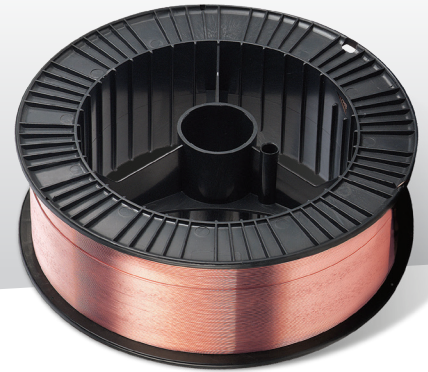
# WESS 70S-6

## MIG/MAG Welding Wire

# W.E.S.S.

WELDING EQUIPMENT SALES & SERVICE

- **High Manganese / Silicon Wire for GMAW (MIG) Welding of Mild & Low Alloy Steels.**
- **Argon Based and CO<sub>2</sub> Shielding Gases.**



### DESCRIPTION & APPLICATION:

WESS 70S-6 is a premium quality, Precision Layer Wound, copper coated, all positional welding wire suitable for Gas Metal Arc Welding (GMAW) / (MIG) welding of mild and low alloy steels, used in general industry for steel fabrication.

Precision Layer Wound and high-quality copper coating ensures smooth stable feedability. The higher silicon content delivers improved fillet shape and optimal side wall fusion with very low spatter levels, reducing the need for post weld cleanup.

### STORAGE:

To maintain in premium condition, product should be stacked on racks or pallets clear of the floor and walls in a heated, weather proof store area maintaining an ambient temperature of 25° C to a maximum of 40° C and at a maximum humidity of 60% R.H. Avoid damp, wet areas.

### CLASSIFICATION:

- AS/NZS 14341-B G 49A 3UM/C S6
- AWS 5.18-ER70S-6

### APPROVALS:

- Lloyd's Register of Shipping Grade: 3YS
- American Bureau of Shipping Grade: 3YSA

Note: Approvals under Mixed gas (M24) and 100% CO<sub>2</sub>.

### TYPICAL WIRE ANALYSIS:

C: 0.07% Mn: 1.55% Si: 0.88% S: 0.012% P: 0.015%

### TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

1.0-2.0 mls of hydrogen / 100 gms of deposited weld metal.

### TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

	Argon + 20-25% CO <sub>2</sub>	Welding Grade CO <sub>2</sub>
Yield Stress	450 MPa	410 MPa
Tensile Strength	550 MPa	525 MPa
Elongation	29%	32%
CVN Impact Value	95 J @ -30° C	90 J @ -30° C

### RECOMMENDED SHIELDING GAS:

Ar+10-15% CO <sub>2</sub> or equivalent	ISO 14175: M21, M24, M14
Ar+15-30% CO <sub>2</sub> or equivalent	ISO 14175: M21, M24
Ar+5% CO <sub>2</sub> + 3% O <sub>2</sub>	M23
Welding Grade CO <sub>2</sub>	C1

### PACKAGING:

Part No.	Description	Spool	Diameter (mm)
S60805	WESS 70S-6 MIG Wire	5 kg Spool	0.8
S60905	WESS 70S-6 MIG Wire	5 kg Spool	0.9
S60815	WESS 70S-6 MIG Wire	15 kg Spool	0.8
S60915	WESS 70S-6 MIG Wire	15 kg Spool	0.9
S61015	WESS 70S-6 MIG Wire	15 kg Spool	1.0
S61215	WESS 70S-6 MIG Wire	15 kg Spool	1.2