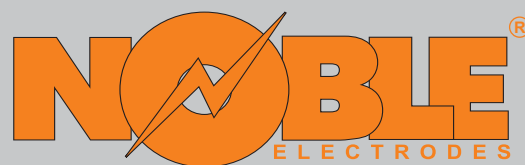


NOBLE - 70S-6

Metal Inert Gas - MIG Wire (Copper Coated)



CLASSIFICATION

AWS - A5.18:ER70S-6

CWB - CSA W48-18: B-G 49A 3 C1 S6 (B-G 49A 3 C G6)

Characteristics :

NOBLE - 70S-6 contains high level of manganese and Silicon de oxidizers which can tolerate medium to heavy mill scale or rusty surface. It provides X-ray quality weld with smooth bead appearance. It provides stable arc, low spatter levels and good feedability.

Applications :

NOBLE - 70S-6 is suitable for the welding of Frame Fabrication, Pressure Vessels, Automotive Structures, Pipe Fabrication, Farm equipments, General Fabrication, Construction Equipment, Railcar construction and repair etc.

Mechanical Properties

Mechanical Tests	AWS Specifications
Tensile Strength	480 N / mm ² (Min.)
Yield Strength	400 N / mm ² (Min.)
Elongation	22 % (Min.)
Impact (CVN) at - 30°C	27 J (Min.)

Chemistry of Wire (%)

Elements	C	Mn	Si	S	P	Cu	Ni	Cr	Mo	V
Range	0.06-0.15	1.40-1.85	0.80-1.15	0.035 Max	0.025 Max	0.50 Max	0.15 Max	0.15 Max	0.15 Max	0.03 Max

Shielding gas: Welding with Co₂ gas and Ar+Co₂ gas mixture

Operating conditions & Packing Specifications

Size (mm)	Current (Amp.) DC (+)	Voltage (V)	Gas Flow Rate L/min.
0.80	70 - 220	16 - 24	10 - 20
1.00	100 - 250	18 - 28	10 - 25
1.20	150 - 300	24 - 34	15 - 25
1.60	150 - 350	24 - 36	15 - 30

“Noble – Characterized by all Excellent Qualities”