

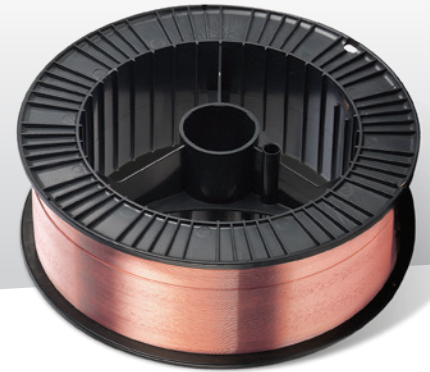
# WESS 70S-6

## 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) |
|----------|---------------------|--------|---------------|
| S60609   | WESS 70S-6 MIG Wire | 0.9 kg | 0.6           |
| S60809   | WESS 70S-6 MIG Wire | 0.9 kg | 0.8           |
| S60909   | WESS 70S-6 MIG Wire | 0.9 kg | 0.9           |
| S60605   | WESS 70S-6 MIG Wire | 5 kg   | 0.6           |
| S60805   | WESS 70S-6 MIG Wire | 5 kg   | 0.8           |
| S60905   | WESS 70S-6 MIG Wire | 5 kg   | 0.9           |
| S61205   | WESS 70S-6 MIG Wire | 5 kg   | 1.2           |
| S60615   | WESS 70S-6 MIG Wire | 15 kg  | 0.6           |
| S60815   | WESS 70S-6 MIG Wire | 15 kg  | 0.8           |
| S60915   | WESS 70S-6 MIG Wire | 15 kg  | 0.9           |
| S61015   | WESS 70S-6 MIG Wire | 15 kg  | 1.0           |
| S61215   | WESS 70S-6 MIG Wire | 15 kg  | 1.2           |