

# Inweld 70S-6

AWS A5.18 ER70S-6

## Chemical Composition of Inweld 70S-6

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	V	Cu
Balance	0.06- 0.15	0.15	0.15	0.15	1.4- 1.85	0.80- 1.15	0.025	0.035	0.03	0.50

Single values are maximum unless otherwise specified.

## Description and Applications

Inweld 70S-6 contains higher levels of manganese and silicon than many other classifications of mild steel wires. The increased Mn and Si content gives stronger deoxidizing power when welding over mild or carbon steel that may have traces of rust or mill scale such as found on structural and plate steels.

Inweld 70S-6 is used for single or multi-pass welding. An excellent choice for sheet metal applications, where the higher silicon content creates excellent "wetting out" properties and produces weld deposits that are essentially flat to slightly convex and require little or no grinding. Weld deposits are x-ray quality.

## Typical Weld Metal Properties

	<u>AWS Spec</u>
Tensile Strength:	70,000 psi
Yield Strength:	58,000 psi
Elongation:	22%
Charpy V-Notch at -20°F:	20 ft/lbs

## Recommended Parameters

GMAW (DCEP - Electrode+) 100 % CO<sub>2</sub>, or a 75-25% Argon/CO<sub>2</sub> Mixture For Solid Wire, 98 % Argon / 2% CO<sub>2</sub> Mixture For Spray Transfer

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>	<u>Wire Feed IPM</u>
0.023"	14-19	30-85	360-620
0.030"	15-20	40-130	390-670
0.035"	16-25	60-235	360-520
0.045"	18-23	90-290	210-360
0.035" (Spray)	23-36	160-300	
0.045" (Spray)	23-29	170-375	
1/16" (Spray)	25-31	275-475	

GTAW (DCEN - Electrode -) 100% Ar 2% Thoriated, or 1.5% Lanthanum Tungsten Electrode

<u>Material</u>	<u>Tungsten Dia.</u>	<u>Filler Wire Size</u>	<u>Amperage</u>	<u>Argon (CFH)</u>
1/16"	1/16"	1/16"	100-140	20
3/32"	1/16"	1/16"	100-160	20
1/8"	3/32"	1/16"	125-200	20
3/16"	3/32"	3/32"	150-250	25
1/4"	1/8"	1/8"	150-250	25

**INWELDCORPORATION.COM**

**Pennsylvania**  
3962 Portland Street  
Coplay, PA 18037

**North Carolina**  
1029 S. Marietta St.  
Gastonia, NC 28054

**Texas**  
9300 Lawndale St.  
Houston, TX 77012

**California**  
6201 Coliseum Way, Unit A  
Oakland, CA 94621