

Lincoln® ER70S-6

AWS ER70S-6 • Mild Steel Cut Length

Key Features

- ▶ High levels of silicon and manganese for use on slightly contaminated base materials
- ▶ More puddle fluidity
- ▶ Excellent wetting action
- ▶ Ink jet printing identification on entire length of electrode
- ▶ Q2 Lot® - Certificates showing actual wire chemistry available online

Conformances

AWS A5.18/A5.18M: 2005ER70S-6
ASME SFA-A5.18: ER70S-6

Welding Positions

All

Typical Applications

- ▶ Repairs on a variety of mild and low alloy steel
- ▶ Small diameter pipe and tubing
- ▶ Sheet metal applications
- ▶ Root pass pipe welding

DIAMETERS / PACKAGING

Diameter in (mm)	5 lb (2.3 kg) Plastic Tube 20 lb (9.1 kg) Master Carton	10 lb (4.5 kg) Plastic Tube 30 lb (13.6 kg) Master Carton	50 lb (22.7 kg) Carton
1/16 (1.6)	ED034334	ED034337	ED034340
3/32 (2.4)	ED034335	ED034338	ED034341
1/8 (3.2)	ED034336	ED034339	ED034342

WIRE COMPOSITION – As Required per AWS A5.18/A5.18M: 2005

	%C	%Mn	%S	%Si	%P
Requirements - AWS ER70S-6	0.06-0.15	1.40-1.85	0.035 max.	0.80-1.15	0.025 max.
Typical Results ⁽²⁾	0.09	<1.60	0.007	0.90	0.007
	%Cu	%Cr	%Ni	%Mo	%V
Requirements - AWS ER70S-6	0.50 max.	(1)	(1)	(1)	(1)
Typical Results ⁽²⁾	0.20	0.05	0.05	0.05	0.05

⁽¹⁾Total 0.50% maximum, combined. ⁽²⁾See test results disclaimer on pg. 18.