

# SUPERGLIDE® S6

Mild Steel, Non-Copper Coated Wire ■ AWS ER70S-6

## KEY FEATURES

- High levels of manganese and silicon deoxidizers tolerate medium to heavy mill scale surfaces
- MicroGuard® Ultra provides superior feeding and arc stability
- Supports short-circuiting, globular, axial spray and pulsed spray transfer
- Non-copper coated

## WELDING POSITIONS

All

## SHIELDING GAS

100% CO<sub>2</sub>  
 75-95% Argon / Balance CO<sub>2</sub>  
 95-98% Argon / Balance O<sub>2</sub>  
 Flow Rate: 30 - 50 CFH

## CONFORMANCES

<b>AWS A5.18/A5.18M:</b>	ER70S-6
<b>ASME SFA-A5.18:</b>	ER70S-6
<b>CWB/CSA W48-06:</b>	ER49S-6
<b>EN ISO 14341-B:</b>	G 49A 3 C S6
<b>MIL-E-23765/1:</b>	MIL-70S-6

## TYPICAL APPLICATIONS

- Medium to heavy mill scale base material
- Sheet metal to 380 - 485 MPa (55 - 70 ksi) yield strength material
- Automotive repair

## DIAMETERS / PACKAGING

Diameter in (mm)	44 lb (20 kg) Fiber Spool	500 lb (227 kg) Accu-Trak® Drum	900 lb (408 kg) Accu-Trak® Drum
0.035 (0.9)	ED028635		ED034560
0.045 (1.1)	ED028636	ED030695	ED034561

## MECHANICAL PROPERTIES<sup>(1)</sup> – As Required per AWS A5.18/A5.18M

	Yield Strength <sup>(2)</sup> MPa (ksi)	Tensile Strength MPa (ksi)	Elongation %	Charpy V-Notch J (ft·lbf) @ -29° C (-20° F)
<b>Requirements<sup>(4)</sup></b> - AWS ER70S-6 As-Welded with 100% CO <sub>2</sub>	400 (58) min	485 (70) min	22 min	27 (20) min
<b>Typical Results<sup>(3)</sup></b> - As-Welded with 100% CO <sub>2</sub>	430 (62)	540 (78)	28	71 (52)

<sup>(1)</sup>Typical all weld metal. <sup>(2)</sup>Measured with 0.2% offset. <sup>(3)</sup>See test results disclaimer <sup>(4)</sup>CTWD (Contact Tip to Work Distance). Subtract 1/4 in (6.4 mm) to calculate Electrical Stickout.