

METALSHIELD® MC-70 XLS®

Mild Steel · AWS E70C-6M-H4

KEY FEATURES

- Minimal silicon islands for an exceptionally clean weld surface
- Minimal post weld clean up
- Best-in-class edge wetting for excellent bead appearance
- Smooth, stable arc characteristics with low spatter levels
- Tolerates welding over mill scale and rust
- Low H4 diffusible hydrogen levels
- High deposition rates and fast travel speeds

WELDING POSITIONS

Flat & Horizontal (CV processes)
Out of Position (Pulse waveforms)

CONFORMANCES

AWS A5.18:	E70C-6M-H4
CWB/CSA:	E491T15-M21A4-CS1-H4, E491T15-M20A4-CS1-H4 [E491C-6MJ-H4]
CSA W48:	E491T15-GA4-CS1-H4 [E491C-6MJ-H4]
AWS D1.8:	0.045 in., 0.052 in., 1/16 in.

TYPICAL APPLICATIONS

- Robotics/Hard Automation
- Structural Fabrication
- Heavy Fabrication
- Pressure Vessels
- Agriculture

SHIELDING GAS

75-92% Argon / Balance CO₂
Flow rate: 40-60 CFH

DIAMETERS / PACKAGING

Diameter in (mm)	33 lb (15 kg) Steel Spool	50 lb (22.7 kg) Fiber Spool	750 lb (340 kg) Accu-Trak® Drum
0.045 [1.1]	ED037105	ED037416	ED037281
0.052 [1.3]	ED037106	ED037417	ED037282
1/16 [1.6]	ED037107	ED037418	ED037283

MECHANICAL PROPERTIES⁽¹⁾

	Yield Strength ⁽²⁾ MPa (ksi)	Tensile Strength MPa (ksi)	Elongation %	Charpy V-Notch J (ft-lbf) @ -29°C [-20°F]
Requirements -				
AWS A5.18: E70C-6M-H4	400 [58] min	480 [70] min	22 min	27 [20] min
AWS A5.36: E70T15-M20A4-CS1-H4		490-660 [70-95]		
Typical Results⁽³⁾				
As-Welded with 75% Argon / 25% CO ₂	450-510 [65-75]	510-590 [75-85]	26-30	40-75 [30-55]
As-Welded with 90% Argon / 10% CO ₂	450-550 [65-80]	550-620 [80-90]	26-30	60-105 [45-75]

⁽¹⁾Typical all weld metal. ⁽²⁾Measured with 0.2% offset. ⁽³⁾See test results disclaimer.

DEPOSIT COMPOSITION⁽¹⁾

	%C	%Mn	%Si	%S	%P	%Cu
Requirements - AWS A5.18: E70C-6M-H4	0.12 max.	1.75 max.	0.90 max.	0.03 max.	0.03 max.	0.50 max.
AWS A5.36: E70T15-M20A4-S1-H4				0.030 max.	0.030 max.	
Typical Performance⁽²⁾ As-Welded with 75% Ar / 25% CO ₂ As-Welded with 90% Ar / 10% CO ₂	0.04-0.07	1.25-1.55 1.25-1.60	0.55-0.80 0.60-0.85	0.010-0.020	0.005-0.010	0.01-0.05
	%Ni	%Cr	%Mo	%V	Diffusible Hydrogen (mL/100g weld deposit)	
Requirements - AWS A5.18: E70C-6M-H4	0.50 max.	0.20 max.	0.30 max.	0.08 max.	4.0 max.	
AWS A5.36: E70T15-M20A4-S1-H4					4 max.	
Typical Performance⁽³⁾ As-Welded with 75% Ar / 25% CO ₂ As-Welded with 90% Ar / 10% CO ₂	0.30-0.40	0.01-0.03	0.01-0.02	0.01-0.02	2-4	

TYPICAL OPERATING PROCEDURES

Diameter, Polarity Shielding Gas	CTWD ⁽⁴⁾ mm [in]	Wire Feed Speed m/min (in/min)	Voltage ⁽⁵⁾ [volts]	Approx. Current [amps]	Melt-Off Rate kg/hr (lb/hr)	Deposition Rate kg/hr (lb/hr)	Efficiency [%]
0.045 in (1.1 mm), DC+ 90% Argon / 10% CO ₂	19-25 (3/4-1)	5.1 (200)	21-23	155	2.3 (5.0)	2.1 (4.6)	92
		6.4 (250)	22-24	185	2.8 (6.2)	2.6 (5.8)	94
		7.6 (300)	22-26	220	3.5 (7.7)	3.2 (7.0)	91
		8.9 (350)	22-27	245	4.0 (8.9)	3.7 (8.2)	93
		10.2 (400)	23-27	260	4.6 (10.1)	4.3 (9.4)	93
		11.4 (450)	23-28	280	5.2 (11.4)	4.9 (10.7)	94
		12.7 (500)	23-29	305	5.7 (12.6)	5.5 (12.2)	97
		14.0 (550)	24-29	315	6.3 (13.9)	6.2 (13.6)	98
		15.2 (600)	25-30	325	6.8 (15.1)	6.7 (14.8)	98
0.052 in (1.3 mm), DC+ 90% Argon / 10% CO ₂	19-25 (3/4-1)	16.5 (650)	26-30	355	7.5 (16.5)	7.4 (16.3)	98
		17.8 (700)	26-30	360	8.0 (17.7)	7.9 (17.5)	99
		5.1 (200)	22-24	210	3.1 (6.8)	2.9 (6.3)	94
		6.4 (250)	22-26	260	3.9 (8.5)	3.5 (7.8)	92
		7.6 (300)	22-27	290	4.6 (10.2)	4.3 (9.5)	94
		8.9 (350)	23-28	315	5.4 (11.9)	5.2 (11.4)	97
		10.2 (400)	24-28	350	6.2 (13.6)	6.1 (13.4)	97
1/16 in (1.6 mm), DC+ 90% Argon / 10% CO ₂	25-32 (1-1 1/4)	11.4 (450)	25-28	370	6.9 (15.3)	6.8 (15.1)	99
		12.7 (500)	27-29	390	7.7 (17.0)	7.6 (16.8)	99
		14.0 (550)	27-30	420	8.4 (18.6)	8.3 (18.3)	99
		3.8 (150)	22-24	230	3.2 (7.0)	2.8 (6.2)	89
		5.1 (200)	22-25	280	4.3 (9.4)	3.9 (8.7)	93
		6.4 (250)	23-27	310	5.3 (11.6)	5.0 (11.0)	94
		7.6 (300)	24-28	370	6.3 (13.9)	6.3 (13.8)	99
8.9 (350)	26-30	400	7.4 (16.3)	7.2 (15.9)	98		
10.2 (400)	26-30	450	8.3 (18.4)	8.3 (18.4)	99		
11.4 (450)	27-31	480	9.5 (21.0)	9.3 (20.6)	98		

⁽⁴⁾To estimate ESO, subtract 3/16 in (4.8 mm) from CTWD. ⁽⁵⁾For greater percentage of CO₂ shielding gas, increase voltage by 1-2 volts.

Safety Data Sheets (SDS) and Certificates of Conformance are available on our website at www.lincolnelectric.com

FUMES AND GASES can be hazardous to your health.

- Fumes from the normal use of this product contain significant quantities of potentially hazardous compounds. See consumable product label/insert.
- Keep your head out of the fumes.
- Use enough ventilation and local exhaust to keep fumes and gases from your breathing zone and the general area.
- An approved respirator should be used unless exposure assessments are below applicable exposure limits.

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

CUSTOMER ASSISTANCE POLICY

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