SuperArc® Orbital TIG L-56® N

Mild Steel • AWS ER70S-6

Key Features

- Q2 Lot® - Certificate showing actual wire composition available online
- Available as Batch Managed Inventory
- "N" Designator - design modified to meet properties after stress relief
- A PLW product which has been treated to minimize weld defects that can be seen in the use of MIG wires for the automatic TIG process.
- Provides a consistent and exceptionally stable arc for automatic TIG welding
- High levels of manganese and silicon deoxidizers tolerate medium to heavy mill scale surfaces
- Excellent toe-wetting provides optimal bead appearance
- Each spool is identified with AWS classification and LOT number

Typical Applications

- Nuclear power plant construction and maintenance
- Power and process industry related piping
- Medium to heavy mill scale base material
- Robotic or hard automation

Welding Positions

All

ASME IX Qualification

ASME IX Qualification: QW432 F-No 6, QW442 A-No 1

Conformances

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

DIAMETERS / PACKAGING

Diameter in (mm)	2 lb (1 kg) Plastic Spool 8 lb (3.6 kg) Master Carton	10 lb (4.5 kg) Plastic Spool
0.035 (0.9)	ED033840	ED033841

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

	%C	%Mn	%Si	%S	%P
Requirements - AWS ER70S-6	0.06-0.15	1.40-1.85	0.80-1.15	0.035 max.	0.025 max.
Typical Results[3]	0.08-0.09	1.42-1.60	0.81-0.87	0.006-0.010	0.004-0.010
	%Cr	**%Ni**	**%Mo**	**%V**	**%Cu (Total)**[4]
Requirements - AWS ER70S-6	0.15 max.	0.15 max.	0.15 max.	0.03 max.	0.50 max.
Typical Results[3]	0.01-0.05	≤ 0.04	≤ 0.01	< 0.01	0.17-0.22

[1]Typical all weld metal. [2]Measured with 0.2% offset. [3]See test results disclaimer on pg. 12. [4]Copper due to any coating on the electrode plus the copper content of the filler metal itself, shall not exceed the stated 0.50% max. [5]CTWD (Contact Tip to Work Distance). Subtract 1/4 in (6.4 mm) to calculate Electrical Stickout. [6]Procedures in these areas are procedures for short circuiting mode using 100% CO_2. When using 75% Argon, 25% CO_2 for short circuit transfer, reduce voltage by 1 to 2 volts.