

# ER70S-6

## Mild Steel Welding Wire

AWS A5.20 E71T-1C/1M KS  
D7104 YFW-C50DR  
JIS Z3313 T49JOT1-1CA-U

### Applications & Features

- ER70S-6 is a GMAW wire.
- It has a wide operation range, with a stable arc and low spatter.
- It is designed for welding in vehicles, shipbuilding, steel structures, bridges and pipes in single pass or multi-pass welding.



### Welding Position:

All positions

### Approvals:

ABS, BV, CR, NK



### Typical chemical composition of weld metal (wt%) (Shielding Gas: 100% CO<sub>2</sub>)

C	Mn	Si	P	S
0.080	1.13	0.60	0.010	0.011

### Typical mechanical properties of weld metal (Shielding Gas: 100% CO<sub>2</sub>)

Tensile Strength N/mm <sup>2</sup> (MPa) (kgf/mm <sup>2</sup> )	Yield Strength N/mm <sup>2</sup> (MPa) (kgf/mm <sup>2</sup> )	Elongation %	Charpy V-Notch	
			°C	J (kgf-m)
555(56.7)	431(44.0)	29	0	80(8.2)
			-30	69(7.1)

### Size & recommended current range (DC+)

Diameter (mm)		0.8	0.9	1.0	1.2	1.4	1.6
Amp	F	50~180	50~200	50~220	80~350	100~470	200~500
	V-up	50~100	50~140	50~140	50~140	100~180	-
	OH	50~100	50~120	50~120	50~160	-	-
	V-down	50~100	50~200	-	-	-	-