

# BT E70C-6M METAL-CORED MIG WIRE

## KEY FACTS

- ◆ AWS A5.18: E70C-6M
- ◆ Automatic or semi-automatic welding
- ◆ Single or multi pass welding
- ◆ Good wetting behaviour
- ◆ Low hydrogen contents ( $\leq 5$  ml/100 g deposit)
- ◆ Efficient high deposition rate
- ◆ Virtually no slag coverage low spatter and smoke levels
- ◆ Excellent bead contour
- ◆ Minimum oxide residues

## DESCRIPTION

E70C-6M is a metal-cored MIG wire can be used for automatic, semi-automatic, single and multiple pass welding on mild steels having a smooth stable arc transfer, spatter free, excellent bead contour, with a high deposition rate and nearly free of slag weld bead.

20% higher productivity can be achieved when compared to solid wires and it features good penetration, high resistance to porosity, good wetting behavior as well as low hydrogen contents ( $\leq 5$  ml/100 g deposit).

Excellent anti-hole performance, suitable for steel plate coated with inorganic zinc primer welding, for the same level of steel welding.

## CLASSIFICATIONS, APPROVALS, CONFORMANCES

AWS A5.18 E70C-6M GB/T10045-2001 E500T-1M  
ISO9001:2000

## RECOMMENDED SHIELDING GAS

80% Ar+20% CO<sup>2</sup> or 85% Ar+15% CO<sup>2</sup>

## WELDING POSITIONS

Horizontal and flat fillet welds



PA

PB

PC

## APPLICATIONS

E70C-6M can be used for steel grades up to yield strength of 480 MPA with only Ar/CO<sub>2</sub> gas mixtures. It is especially suitable for welding and has a high tolerance to primer.

- ◆ Machineries
- ◆ Shipbuilding
- ◆ Offshore structures
- ◆ Bridges
- ◆ General fabrications

## TYPICAL WIRE ANALYSIS

<b>C</b> Carbon	<b>Mn</b> Manganese	<b>Si</b> Silicon
< 0.08	1.75	< 0.9
<b>P</b> Phosphorus	<b>S</b> Sulphur	
< 0.03	< 0.03	

## TYPICAL WELD MECHANICAL PROPERTIES

<b>Yield Strength</b>	MPA 480
<b>Tensile Strength</b>	MPA 400
<b>Elongation</b>	> 22%
<b>Impact Strength</b>	> 27 J @ -20°C

## PACKAGING & ORDERING INFORMATION

Size	Packet	Part Number
1.2mm	15kg	200382
1.6mm	15kg	200383
72 spools /pallet		

*Disclaimer: The above information is provided as a guide; actual welding current and voltage will depend on the welding machine characteristics, which will vary from model to model. Other variables include run length and size, plate thickness, operator technique and gas type (if used). The user must evaluate the process, application and recommended professional advice. Under no circumstance will Dynaweld or its affiliates be liable for misuse or application of products; this is entirely up to the user's ability.*