

MIG-70S

AWS A5.18 ER 70S-6

JIS Z 3312 YGW12



For Mild Steel and 490 N/mm² High Tensile Steel (GMAW)

Characteristics

WELDMAXX MIG-70S is a solid wire to be used in gas metal arc welding (GMAW) process with CO₂ or Ar+CO₂ gas mixture. It assures good arc stability, less spatter and satisfactory weldability in a wide range of welding current. It is suitable for all-position welding.

Applications

Welding of mild steels and 490 N/mm² high tensile steel for automobiles, industrial machinery, pipes, steel frames, bridges and ships.

Typical Chemical Composition of Weld Metal (%)

C	Mn	Si	S	P
0.08	1.13	0.6	0.011	0.01

Typical mechanical properties of weld

Tensile Strength	Yield Strength	Elongation	Impact Value(-29°C)
N/mm ² (kgf/mm ²)	N/mm ² (kgf/mm ²)	%	J (kgf/mm ²)
431(44.0)	555(56.7)	29	69(7.1)

Shield gas: CO₂

Sizes and Operating Data

Size (mm)	Voltage (volts)	Wire Feed Speed (m/min)	Current (amps)
0.8	14 ~ 22	3.5 ~ 14	50 ~ 180
0.9	15 ~ 26	3.5 ~ 15	70 ~ 230
1.0	16 ~ 29	3.5 ~ 15	100 ~ 280
1.2	18 ~ 32	2.5 ~ 15	120 ~ 350
1.6	18 ~ 34	2.5 ~ 10	180 ~ 390

Notes on usages

1. Distance between base metal and the contact tip in the nozzle must be kept between 15~25mm.
2. The proper welding conditions must be adopted according to the purpose as the bead appearance and penetration are varied depending on the welding conditions

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No.	D	H	Diameter	Weight
DRUM 1	513 mm / 20.19" +/-5 mm	500 mm / 19.68" +/-50 mm	0.8 / 0.9 / 1.0 mm .035" / .045"	100 kg 250 lbs
DRUM 2	513 mm / 20.19" +/-5 mm	820 mm / 32.28" +/-50 mm	0.9 / 1.0 / 1.2 mm .035" / .045" / .063"	250 kg 500 lbs
DRUM 3	663 mm / 26.10" +/-5 mm	770 mm / 30.31" +/-50 mm	1.2 mm above .045" above	350 kg 750 lbs

