

# BT 70S-6 CF COPPER FREE MIG WELDING WIRE

## KEY FACTS

- ◆ Excellent arc ignition
- ◆ Extremely low fume emission
- ◆ Trouble free feedability
- ◆ Stable arc
- ◆ High current operability

## DESCRIPTION

A premium, precision layer wound, Copper Free MIG Welding Wire for use with Ar/CO<sub>2</sub> shielding gas.

Recommended for single or multipass welding of low carbon and low alloy high strength steel with 500Mpa grade. Approved for all welding positions including vertical down.

## CLASSIFICATIONS, APPROVALS, CONFORMANCES

AWS A5.18: ER70S-6

DIN EN ISO 14341-A-G 42 4 C1/M21 3Si1

Approvals: CE, TUV, DB

## RECOMMENDED SHIELDING GAS

80% Ar - 20% CO<sub>2</sub>

## WELDING POSITIONS

All positional, including vertical-down



PA

PB

PC

PD

PE

PF

PG

## APPLICATIONS

Most suitable in production or general fabrication where highest deposition rates and low spatter is required including farm machinery, construction equipment and carbon steel fabrication.

- ◆ Tube sections
- ◆ General steel repairs
- ◆ Construction and manufacturing
- ◆ Structural steel

## TYPICAL WIRE ANALYSIS

<b>C</b> Carbon	<b>Mn</b> Manganese	<b>Si</b> Silicon	<b>Cr</b> Chromium	<b>Ni</b> Nickel
0.06 - 0.14	1.4 - 1.6	0.8 - 1.0	< 0.15	< 0.15
<b>Mo</b> Molybdenum	<b>S</b> Sulphur	<b>P</b> Phosphorus	<b>Cu</b> Copper	<b>V</b> Vanadium
< 0.15	< 0.025	< 0.025	< 0.20	< 0.03

## TYPICAL WELD MECHANICAL PROPERTIES

<b>Yield Strength</b>	MPA > 420
<b>Tensile Strength</b>	MPA 520 - 640
<b>Elongation</b>	> 22%
<b>Impact Strength</b>	30 J @ -40°C

## PACKAGING & ORDERING INFORMATION

Size	Packet	Part Number
0.9mm	18kg	200013
1.2mm	18kg	200014
1.2mm	250kg	200014P
56 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.*