

# BW-ER70S-6Z

## Non-Copper Coated (NCC) ER70S-6Z MIG Wire

AWS A5.18 ER70S-6 (Z) JIS Z3312 YGW-12 EN440 G3 Si 1

ER-70S-6Z is manufactured with no copper coating to eliminate copper flaking and reduce copper fumes. ER70S-6 contains higher levels of manganese and silicon than other standard grades and it is suitable for automatic welding. Manufactured under a quality system certified to ISO 9001 requirements.

### Applications & Features

Butt and fillet welding of sheet and plate of a variety of thickness, such as vehicles, building, ships, machinery and bridges in all positions.

### Characteristics

Excellent feeding ability and arc-restart for robot welding especially, very consistent welding performance.

### Notes on Usage

Good spatter control, low fume productions. Properly control the flow of shielding gas approx. 20 ~ 25 ℓ/min. Maintain outstretching length of wire between tip & base metal in the range of 15 ~ 20 mm.

### Approvals

JIS Z3312 YGW-12  
EN440 G3 Si 1



### Typical chemical composition of weld metal (wt%)

Shielding Gas	C	Mn	Si	P	S
100% CO <sub>2</sub>	0.08	1.13	0.60	0.010	0.011
Ar + 20% CO <sub>2</sub>	0.07	1.18	0.63	0.010	0.010

### Typical mechanical properties of weld metal

Shielding Gas	Tensile Strength N/mm <sup>2</sup>	Yield Strength N/mm <sup>2</sup>	Elongation %	Charpy V-Notch J (kgf•m) - 29°C
100% CO <sub>2</sub>	555	441	29	69 (7.1)
Ar + 20% CO <sub>2</sub>	580	478	27	80 (8.2)

### Size available and recommended currents (DC+)

Dia. mm	0.8/0.9	1.0	1.2	1.4	1.6
Current	F	50~200	50~220	80~350	140~400
Amp	V & OH	50~120	50~150	50~160	100~250

### Package

Dia. mm	0.8	0.9	1.0	1.2	1.4	1.6
Spool kg	1/5/15/20	1/5/15/20	1/5/15/20	5/15/20	15/20	15/20
Pail Pack kg	100/200	100/200	100/250	100/250	350	350