

# WELDING CONSUMABLES

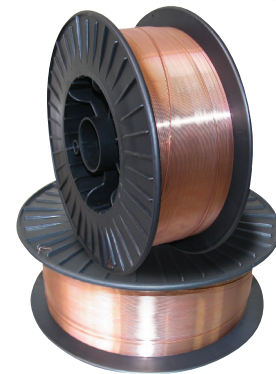
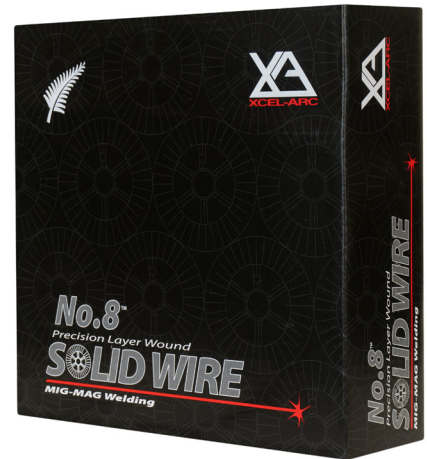
## SOLID MIG WIRE ER70S-6



### XCEL-ARC No.8 Wire

#### ER70S-6 SOLID MIG WIRE Precision Layer Wound

- High Quality
- Triple De-oxidised
- X-Ray Quality
- Precision Layer Wound
- Smooth Feeding
- Clean Weld Finish
- International Approvals (5kg and 15kg Spools)
  - EN ISO14341-A-G 42 3C1/M21 3Si1
  - Llyods Register of Shipping
  - Det Norske Veritas
  - American Bureau of Shipping
  - Germanischer Llyod
  - Canadian Welding Bureau



#### Typical Applications:

Structural Steel - General Fabrication - Light Fabrication  
Transport Industry - Heavy Equipment - Farm Machinery  
Pressure Vessels - Robotic and Semi Automatic Welding Applications

#### Application Notes:

Xcel-Arc No.8 ER70S-6 is a high quality, copper coated, triple de-oxidised solid mig welding wire supplied on 15kg, 5kg and 1kg Plastic Spools. XA No.8 is a mild steel welding wire that contains higher levels of manganese and silicon than other standard grades of MIG wire to produce high quality welds when used on dirty, oily, or rusty steel. The high silicon content increases the fluidity of the weld pool, thus creating a smoother bead appearance and resulting in minimal post-weld grinding. XA No.8 wire is engineered to provide porosity-free, x-ray quality welds at the highest tensile strength (as welded) of all the plain carbon steel wires. ER70S-6 Solid Mig Wire requires a shielding gas: CO<sub>2</sub> or ArgonCO<sub>2</sub> mix. Xcel-Arc No.8 wire is Precision Layer Wound for smooth uninterrupted wire feed with less liner and tip wear.

#### Chemical Composition

≤C 0.07 ≤Si 0.91 ≤Mn 1.42 ≤P 0.012 ≤S 0.012 ≤Ni 0.011 ≤Cr 0.012 ≤Mo 0.01 ≤V 0.01

#### Typical Mechanical Properties of Weld metal

Yield Strength	Tensile Strength	Elongation	Impact Values	Test Temperature
440 MPa	545 MPa	30.0%	70 ft. lbf	-30°F

Part-No	Description	Spool Weight
XAN80601	0.6mm XcelArc ER70S-6 Mig Wire	1kg
XAN80801	0.8mm XcelArc ER70S-6 Mig Wire	1kg
XAN80901	0.9mm XcelArc ER70S-6 Mig Wire	1kg
XAN80605	0.6mm XcelArc ER70S-6 Mig Wire	5kg
XAN80805	0.8mm XcelArc ER70S-6 Mig Wire	5kg
XAN80905	0.9mm XcelArc ER70S-6 Mig Wire	5kg
XAN80815	0.8mm XcelArc ER70S-6 Mig Wire	15kg
XAN80915	0.9mm XcelArc ER70S-6 Mig Wire	15kg
XAN81015	1.0mm XcelArc ER70S-6 Mig Wire	15kg
XAN81215	1.2mm XcelArc ER70S-6 Mig Wire	15kg

