








STAR ER 70S-6 MIG WELDING WIRE

CHARACTER

AWS - 5.18 ER 70S 6, IS - 6419 S-4

EN - 440 G 46 3 M G4 Si 1

SIZE	APROVALS
0.8 mm,1.00mm.1.2 mm and 1.6 mm	BHEL

SHIELDING GAS	SUITABLE FOR
Ar 80% +20 % co2	    

CHEMICAL COMPOSITION OF WELD METAL

C%	Mn%	Si%	S%	P%	Cr%	Ni%	Cu%
0.06-0.15	1.40-1.85	0.80-1.15	0.035 max	0.025 max	0.15	0.15	0.5

Including Cu in the coating

MECHANICAL PROPERTIES OF WELD METAL

UTS	YS	ELONGATION (L=4d)%	CVN impact Value at -30°C
490 N/mm2	400 N/mm2	22	22 J

WELD PARAMETER SETTING FOR FLAT WELDING (F) AND POSITION WELDING (P)

SIZE	VOLT	AMPS	GAS FLOW	STICK OUT	SPOOL WT	DRUM WT
0.8 MM	18-26	100-200	15- 20 LPM	10- 20 MM	12.5/15 KG	100/125 KG
1.0 MM	18-30	150-300	15- 20 LPM	10- 20 MM	15 KG	250 KG
1.2 MM	20-32	200-350	15- 20 LPM	10- 20 MM	15 KG	250 KG
1.6 MM	24-35	275-450	15- 20 LPM	10- 20 MM	15 KG	250 KG

APPLICATIONS:

Star brand highly used in automotive component manufacturing industry, construction, fabrication, thin sheet metal welding, pipe welding and pressure vessel fabrication industries.

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