



# Test certificate

Special wire products (p)  
235, Sidco Industrial Estate  
Ambattur, Chennai-60009

Product : MIG WELDING WIRE  
Grade : ER70S-6

Test certificate no : 426

Character : AWS - 5.18 ER 70s 6, IS - 6419 S-4 Batch No :  
E8566040011A0307  
Size :  $\varnothing$  1.2 mm

Email : [sales@specialwires.in](mailto:sales@specialwires.in) Web site : [www.specialwire.in](http://www.specialwire.in)

This is to certify that all tests required by the specifications shown for classification were performed, and the material tested met all requirements. It is manufactured and supplied as per the Quality system program of SWP, which meets the requirements of ISO 9001, ANSI/AWS A5.01 and other specifications applicable.

OPERATING PARAMETERS	SIZE OF WIRE(MM)	POLARITY CURRENT TYPE	SHIELDING GAS	NOMINAL VOLTAGE (V)	NOMINAL CURRENT, (A)	STICK OUT DISTANCE, (MM)	GAS FLOW
SPECIFICATION	$\varnothing$ 1.2 - 0.05	DC+	80%Ar +20%CO2	20-32	200-350	10-20	1
ACTUAL	$\varnothing$ 1.15	DC+	80%Ar + 20%CO2	25	260	16	
RESULT	OK	OK	OK	OK	OK	OK	

## CHEMICAL COMPOSITIONS OF WIRES

CHEMICAL COMPOSITIONS	C	Mn	SI	P	S	Cr	Ni
SPECIFICATION	0.06-0.15	1.40-1.85	0.80-1.15	0.025 MAX	0.035MAX	0.150 Max	0.150 Max
ACTUAL	0.073	1.46	0.9	0.013	0.007	0.018	0.007
RESULT	OK	OK	OK	OK	OK	OK	OK

## MECHANICAL PROPERTIES OF WIRE

MECHANICAL PROPERTIES	Tensile strength [N/mm <sup>2</sup> ]	Yield Strength [N/mm <sup>2</sup> ]	Elongation %	Average
SPECIFICATION	490 min	400 min	22 min	25
ACTUAL	521	465	24	25
RESULT	OK	OK	OK	OK

Note :



Radiographic inspection : Met requirements

Ref  
No:048/0005  
DATE:02.12.19



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Quality As:

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is  
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LOW L/M
5-20
15
OK

Copper Coating % (CU)
0.50MAX
0.31
OK

age impact y J@-30°C
2 min

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