Special Wires

STAR®

Test certificate

Special wire products (p) Ltd.,
235, Sidco Industrial Estate,
Ambattur, Chennai-600098

Product : MIG WELDING WIRE
Grade : ER70S-6
Character : AWS - 5.18 ER 70s 6, IS - 6419 S-4
Batch No : E8566041101A0307
Size : Ø 0.8 mm

Test certificate no : 425
Email : sales@specialwires.in
Web site : 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 specification, as applicable.

OPERATING PARAMETERS	SIZE OF WIRE(MM)	POLARITY CURRENT TYPE	SHIELDING GAS	NOMINAL VOLTAGE (V)	NOMINAL CURRENT, (A)	STICK OUT DISTANCE, (MM)	GAS FLOW L/M
SPECFICATION	Ø 0.8 - 0.05	DC+	80%Ar +20%CO2	18-26	100-200	10-20	15-20
ACTUAL	Ø 0.77	DC+	80%Ar + 20%CO2	23	160	15	17
RESULT	OK	OK	OK	OK	OK	OK	OK

CHEMICAL COMPOSITIONS OF WIRES

CHEMICAL COMPOSITIONS	C	Mn	SI	P	S	Cr	Ni	Copper Coating % (CU)
SPECFICATION	0.06-0.15	1.40-1.85	0.80-1.15	0.025 MAX	0.035MAX	0.150 Max	0.150 Max	0.50MAX
ACTUAL	0.073	1.46	0.9	0.013	0.007	0.018	0.007	0.31
RESULT	OK	OK	OK	OK	OK	OK	OK	OK

MECHANICAL PROPERTIES OF WIRE

MECHANICAL PROPERTIES	Tensile strength [N/mm2]	Yield Strength [N/mm2]	Elongation %	Average impact energy J@-30°C
SPECFICATION	490 min	400 min	22 min	22 min
ACTUAL	521	465	24	25
RESULT	OK	OK	OK	OK

Note :

Radiographic inspection : Met requirements

Ref No:048/0005

DATE:02.12.19

SPECIAL WIRE PRODUCTS (P) LTD. Chennai 600 098

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Quality Assurance