

Product : MIG WELDING WIRE
Grade : ER70S-6
Character : AWS - S. 38 ER 70S6, IS - 6419 S-4
Batch No : A30567341012C3806
Size : \varnothing 1.20mm

Test certificate no : 713
Email : sales@specwire.in
Web site : www.specwire.in
MFD : 18.06.2022

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 SPL, which meets the requirements of ISO 9001, AWS/KNAS AS.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)
SPECIFICATION	\varnothing 1.20-0.05	DC+	80%Ar +20%CO ₂	20-32	200-350	10-20	15-20
ACTUAL	\varnothing 1.16	DC+	80%Ar + 20%CO ₂	24	221	15	16
RESULT	OK	OK	OK	OK	OK	OK	OK

CHEMICAL COMPOSITIONS OF WIRES

CHEMICAL COMPOSITIONS	C	Mn	Si	P	S	Cr	Ni	Copper Coating % (CU)
SPECIFICATION	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	0.075	1.50	0.850	0.015	0.009	0.023	0.01	0.27
RESULT	OK	OK	OK	OK	OK	OK	OK	OK

MECHANICAL PROPERTIES OF WIRE

MECHANICAL PROPERTIES	Tensile strength [N/mm ²]	Yield Strength [N/mm ²]	Elongation %	Average Impact energy J@-30°C
SPECIFICATION	490 min	400 min	22 min	27 J

ACTUAL	633	480	24	27
RESULT	OK	OK	OK	OK

Note:

Radiographic inspection: Met requirements

Ref No:048/0005

DATE:02.12.19



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Quality Assurance