



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 : M370506600
Size : Ø 1.2mm

Test certificate no : 1415
Email : sales@specialwires.in
Web site : www.specialwire.in
MFD : 25-07-2023

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, 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
SPECIFICATION	Ø1.20-0.05	DC+	80%Ar +20%CO2	20-32	200-350	10-20	15-20
ACTUAL	1.18	DC+	80%Ar + 20%CO2	27	244	13	19
RESULT	OK	OK	OK	OK	OK	OK	OK

CHEMICAL COMPOSITIONS OF WIRES

CHEMICAL COMPOSITIONS	C	Mn	S	P	Si	Cr	Ni	Copper Coating % (CU)
SPECIFICATION	0.0600-0.0800	1.4200-1.5000	0.0200 MAX	0.0200 MAX	0.8000-0.9000	0.0500 Max	0.1500 Max	0.1000 MAX
ACTUAL	0.0740	1.4630	0.0090	0.0190	0.8650	0.0199	0.0200	0.0090
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
SPECIFICATION	490 min	400 min	22 min	22J
ACTUAL	642	497	26	22J
RESULT	OK	OK	OK	OK

Note :

Radiographic inspection : Met requirements

Ref No:048/0005

DATE:02.12.19



Quality Assurance