



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 : F938427
Size : Ø1.00 MM

Certificate No : 1438
Email : sales@specialwires.in
Web site : www.specialwire.in
MFD : 02-08-2023

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	Ø1.00MM-0.05	DC+	80%Ar +20%CO2	18-30	150-300	10-20	15-20
ACTUAL	0.96	DC+	80%Ar + 20%CO2	25	169	15	18
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	0.035 MAX	0.150 MAX	0.150 MAX	0.50 MAX
ACTUAL	0.066	1.46	0.853	0.015	0.006	0.022	0.009	0.008
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	400 MAX	550 MAX	20 MIN	22J
ACTUAL	527	455	24	22J
RESULT	OK	OK	OK	OK

Note :

Radiographic inspection : Met requirements

Ref No:048/0005

DATE:02.12.19



Quality Assurance