



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 : M410326600
Size : Ø0.80 MM

Certificate No : 1508
Email : sales@specialwires.in
Web site : www.specialwire.in
MFD : 16-09-2023

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	Ø0.80MM-0.05	DC+	80%Ar +20%CO2	18-26	100-200	10-20	15-20
ACTUAL	0.79	DC+	80%Ar + 20%CO2	24	167	14	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	0.060-0.080	1.42-1.50	0.80-0.90	0.020 MAX	0.020 MAX	0.050 MAX	0.150 MAX	0.10 MAX
ACTUAL	0.061	1.49	0.880	0.020	0.009	0.022	0.022	0.007
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	525 MAX	400 MAX	20 MIN	22
ACTUAL	501	385	41	22
RESULT	OK	OK	OK	OK

Note :

Radiographic inspection : Met requirements

Ref No:048/0005

DATE:02.12.19



svs
Quality Assurance