



# Test certificate

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

Brand : STAR  
Product : MIG WELDING WIRE  
Classification : ER70S-6  
Specification : AWS A5.18-2017;ASME SFA A5.18  
Batch No : E961563  
Size  $\phi$  : 1.20 mm

Test certificate no : 1582  
MFD : 08.03.2024  
Email : [sales@specialwires.in](mailto:sales@specialwires.in)  
Web site : [www.specialwire.in](http://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 ANSI/AWS A5.18-2017 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	$\phi$ 1.2 - 0.05	DC+	80%Ar + 20%CO2 (or) 100% Co2	20-32	200-350	10 - 20	15-20
ACTUAL	$\phi$ 1.165	DC+	80%Ar + 20%CO2 (or) 100% Co2	28	257	19	17

RESULT : The Operating Parameters met the requirements of AWS A5.18-2017;ASME SFA A5.18

## CHEMICAL COMPOSITIONS OF WIRE

CHEMICAL COMPOSITIONS	C	Mn	SI	P	S	Cr	Ni	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	0.080	1.43	0.849	0.015	0.004	0.021	0.010	0.007

RESULT : The Chemical Composition of the wires met the requirements of AWS A5.18-2017;ASME SFA A5.18

## MECHANICAL PROPERTIES OF WELDED

MECHANICAL PROPERTIES	Tensile strength [N/mm2]	Yield Strength [N/mm2]	Elongation %	Average impact energy J@-30°C					
SPECIFICATION	480 min	400 min	22 min	27					
ACTUAL	575	521	23	1	2	3	4	5	AVG
				124	126	127	133	131	128

RESULT : The Mechanical Properties of the welded met the requirements of AWS A5.18-2017;ASME SFA A5.18

Rev No: 02  
Rev Date : 09.11.2023

Quality Assurance