



MILD STEEL MIG WIRES

ER70S-6

CWB to CSA W48-14
 Classification: B-G 49A 3 C1 56 (B-G 49A 3 C GG)
 AWS/ASME A5.18/A5.18M:2005

Suitable welding positions



Typical applications

Mild steel wire for welding of mild steel and 490MPa tensile strength materials. Widely used in the fabrication of auto parts, truck bodies, heavy equipment and farm implements. Also commonly used for HVAC duct work, structural applications, pipes, steel castings or forgings, shaft build-ups and general shop fabrications.

Characteristics on usage

- Excellent mechanical and toughness properties in low temperature conditions
- High silicone content ensures a highly fluid weld pool and excellent wetting
- Very low spatter generated
- Well suited for sheet metal applications that require a high welding current without burn through
- Mig wire spools are precision wound

Typical chemical composition of all-weld-metal(%)

C	Si	Mn	p	S
0.07	0.67	1.20	0.015	0.011

Typical mechanical properties of all-weld-metal

Yield Strength		Tensile Strength		Elongation	Gas Mixture	Impact Value
450 MPa	65 ksi	550 MPa	80 ksi	30%	100% c o ²	??J (-30° c)
480 MPa	70 ksi	580 MPa	84 ksi	28%	AR +20% c o ²	80J (-30° c)

Dimensions and recommended currents

Vanguard Code & Package Size			Diameter		Amperage (A)	Voltage (V)
5 Kg	15/20 Kg	300 Kg	mm	inches		
6910 0506	6910 2006	---	0.6	0.023	70 - 80	14 - 18
6910 0508	6910 2008	6910 0308	0.8	0.030	70 - 200	14 - 20
6910 0509	6910 2009	6910 0309	0.9	0.035	70 - 250	14 - 25
---	6910 2012	6910 0312	1.2	0.045	100 - 350	16 - 34
---	---	6910 0314	1.4	0.052	120 - 400	16 - 36
---	6910 2016	6910 0316	1.6	0.062	120 - 450	16 - 38

Available packaging

Mig Wire 5 and 20 Kg Spools and/or 300 Kg Drums
 Not all available packaging are standard stock items

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Typical chemical composition of all-weld-metal(%)

C	Si	Mn	P	S
0.07	0.86	1.53	0.012	0.007

Typical mechanical properties of all-weld-metal

Yield Strength		Tensile Strength		Elongation	Gas Mixture	Impact Value
450 MPa	65 ksi	550 MPa	80 ksi	30%	100% c o ²	∅QJ (-30° c)
480 MPa	70 ksi	580 MPa	84 ksi	28%	AR +20% c o ²	80J (-30° c)

Dimensions and recommended currents

Vanguard Code & Package Size				Diameter		Amperage (A)	Voltage (V)
1 Kg	5 Kg	20 Kg	250 Kg	mm	inches		
6910 0106V	6910 0506V	—	—	0.6	0.023	50 - 120	9 - 14
6910 0108V	6910 0508V	6910 2008V	—	0.8	0.030	60 - 250	12 - 24
6910 0109V	69100509V	6910 2009V	6910 0259V	0.9	0.035	70 - 250	14 - 25
—	—	6910 2012V	6910 0212V	1.2	0.045	100 - 350	16 - 34
—	—	6910 2016V	—	1.6	0.062	70 - 250	14 - 25

Available packaging

Mig Wire 1, 5 and 20 Kg Spools and/or 250 Kg Drums
 Not all available packaging are standard stock items