

Troubleshooting General

Welding spatters on 70S6 wire can be caused by several factors such as improper welding technique, incorrect voltage or amperage settings, or a contaminated workpiece or wire. Here are some possible solutions to reduce welding spatters on 70S6 wire:

1. Check your welding technique: Welding spatters can occur if you're using improper welding technique. You should maintain a consistent travel speed and angle, as well as a steady stick-out length. Welding too slowly can cause the wire to overheat and create more spatter. On the other hand, welding too fast can cause the weld bead to be insufficiently penetrated, leading to more spatters.
2. Adjust voltage and amperage settings: Incorrect voltage or amperage settings can also lead to welding spatters. Make sure you are using the correct settings for your specific welding application. Lower voltage and amperage settings can also reduce spatters.
3. Clean the workpiece and wire: Make sure the workpiece and wire are clean and free from any oil, rust, or other contaminants. Use a wire brush or grinder to remove any surface contamination before welding.
4. Use a spatter-reducing agent: You can also use a spatter-reducing agent to reduce welding spatters. These agents help prevent spatters from sticking to the workpiece and wire by creating a barrier between the two.
5. Use a different wire: If the above solutions don't work, consider using a different type of wire that is more suited to your welding application.

Remember that welding spatters can be hazardous, so always wear proper protective equipment like welding gloves, helmets, and clothing.

MIG / MAG WELDING TROUBLESHOOTING GUIDE

Fault or defect:

Poor Weld Starts

Probable cause:

Voltage too low.

Too much stick out (stubbing).

Wire not clipped on an angle (stubbing).

Excessive Spatter

Voltage too low.
Change gas selection (from CO-2 to Steelmix) Change polarity.

Burn Through

Current too high.
Travel speed too slow.
Too large a gap
Change gas section (from CO-22 to Steetmix)

Convex Bead

Voltage/current too low.
Too much stick out.
Voltage loss due to poor connections.

TEST RESULTS

Test results should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

PROPER STORAGE

After manufacturing Bonarc stainless steel electrodes are packaged in re-sealable plastic bags, then inserted in plastic sleeves. These plastic sleeves provide protection from damage and moisture.

When stored under normal conditions the electrodes will very slowly pick up moisture.

5-15 °C (41-59°F) – Relative humidity ::
5 60% 15-25°C (59-77°F) – Relative humidity ::5 50%
25°C (> 77°F) – Relative humidity ::5 40%

RE-DRYING OF COVERED ELECTRODES

Prior to leaving the factory the humidity level of all Bo narc stainless steel electrodes are verified. If during storage the electrodes do pick up moisture/humidity re-drying of the electrodes is an easy method to correct this “issue”.

Bonarc stainless steel electrode should be re-dried prior to use at between 300 – 350 °C for 30 to 60 minutes. No more than four layers of electrodes should be dried at a time.