

Eureka Welding Alloys

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TECHNICAL DATA FOR EUREKA ER70S-6 SOLID MIG WIRE

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INTRODUCTION

Eureka ER70S-6 Solid MIG Wires are drawn, cleaned, spooled and packaged to obtain smooth wire feeding with a stable spatter free arc. These wires are designed for the most critical applications where weld metal cleanliness is most important.

METALLURGICAL CHARACTERISTICS

All weld metal deposits display approximately 85,000 P.S.I. tensile strength with 25% elongation.

RECOMMENDED APPLICATIONS

Eureka ER70S-6 Solid Wire can be used for general repair or fabrication of low alloy and mild steels and for use as an underlay prior to the deposition of a hard facing alloy. It is use for the joining and heavy buildup of low alloy and mild steels. This fully deoxidized filler metal yields dense porous free weld deposits.

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WELDING PARAMETERS

SIZE	AMPERAGE	VOLTS
.035" 1.0mm	100 – 225	14 – 28
.045" 1.2mm	125 – 250	16 – 28
1/16" 1.6mm	180 – 400	22 – 33

Use DC Current with a Stick Out of
1/4" - 1 1/4" (6mm-32mm)

RECOMMENDED SHIELDING GASES

75% Argon, 25% Co2

90% Argon, 10% Co2

92% Argon, 8% Co2

100% CO2 may produce lower quality arc conditions

GAS FLOW RATE

20-60 CFH

TYPICAL CHEMISTRY

C	Mn	Si
.10	1.5	1.0