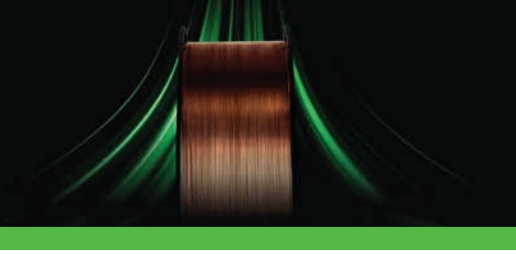
BT WELD



BT WELD E70C-6M METAL-CORED MIG WIRE

KEY FACTS

- AWS A5.18: E70C-6M
- Automatic or semi-automatic welding
- Single or multi pass welding
- Good wetting behaviour
- Low hydrogen contents (≤ 5ml / 100g deposit)
- Efficient high deposition rate
- Virtually no slag coverage low spatter & smoke levels
- Excellent bead contour
- Minimum oxide residues

DESCRIPTION

E70C-6M is a metal-cored MIG wire can be used for automatic, semi-automatic, single and multiple pass welding on mild steels having a smooth stable arc transfer, spatter free, excellent bead contour, with a high deposition rate and nearly free of slag weld bead.

20% higher productivity can be achieved when compared to solid wires and it features good penetration, high resistance to porosity, good wetting behavior as well as low hydrogen contents (≤ 5 ml/100 g deposit).

Excellent anti-hole performance, suitable for steel plate coated with inorganic zinc primer welding, for the same level of steel welding.

CLASSIFICATIONS

AWS A5.18 E70C-6M GB/T10045-2001 E500T-1M
ISO9001:2000

RECOMMENDED SHIELDING GAS

80% Argon + 20% CO2
85% Argon + 15% CO2

WELDING POSITIONS

Horizontal and flat fillet welds



PA PB PC

APPLICATIONS

E70C-6M can be used for steel grades up to yield strength of 480 MPA with only Ar/CO2 gas mixtures. It is especially suitable for welding and has a high tolerance to primer.

- Structural or general steel fabrication
- Construction of rural equipment
- Machinery and piping
- Construction of ships & storage vessels
- Offshore structures
- Bridges

TYPICAL WIRE ANALYSIS

C Carbon	Mn Manganese	Si Silicon
< 0.08	1.75	< 0.9
P **Phosphorus**	**S** **Sulphur**	
< 0.03	< 0.03	

TYPICAL WELD MECHANICAL PROPERTIES

Yield Strength	480 MPa
Tensile Strength	400 MPa
Elongation	> 22%
Impact Strength	> 27 J @ -20°C

PACKAGING & ORDERING INFORMATION

Size	Packet	Part Number
1.2mm	15kg	200382
1.6mm	15kg	200383
Pallets are 1080kg (72 D300 spools)		

Disclaimer: The above information is provided as a guide; actual welding current and voltage will depend on the welding machine characteristics, which will vary fro model to model. Other variables include run length and size, plate thickness, operator technique and gas type (if used). The user must evaluate the process, application and recommended professional advice. Under no circumstance will Dynaweld or its affiliates be liable for misuse or application of products; this is entirely up to the user's ability.