



M-90 ER70S-6

FEATURES

- *GOOD PERFORMANCE
- *HIGH DEPOSITION
- *GOOD BEAD APPEARANCE

APPLICATION

PIPES, SHIPBUILDING, AUTOMOTIVE, MACHINERY

CLASSIFICATION

*AWS/A5.18/ ASME SFA5.18
ER70S-6

CHEMICAL COMPOSITIONS

C	Si	Mn	P	S	CR	Ni	MO
0.07	0.85	1.5					

MECHANICAL PROPERTIES

Y.S	T.S	EL	Temp.	CVN-Impact Value
N/mm2 (lbs/in 2)	N/mm2 (lbs/in 2)	(%)	oC (oF)	J (ft lbs)
450 (65,300)	520 (75,500)	28	-20 (-4)	180(132)

WELDING PARAMETERS

DIAMETER (mm)	1.6	2.4
LENGTH (mm)	1000	1000
CURRENT (amps)		

CURRENT

DC -

GAS

Ar

WELDING POSITIONS

Current

= + ~ (U_o: 50 V)



ASME:	1G	2F	2G	3G	3G	4G	5G
ISO 6947	PA	PB	PC	PF	PG	PE	PF/PG
