



## **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<sub>o</sub>: 50 V)



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

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