

# GM 70

## IDENTIFICATION

GM 70, ER 70S6

## CLASSIFICATION

AWS/SFA 5.18: ER70S-6C, JIS Z3312 YGW12, IS 814: 2004, EN ISO 14341-A: G 42 4 M21 3Si1

## DESCRIPTION

GM 70 is copper coated solid wire designed for all position welding by short-circuiting type transfer. As the deposition efficiency is high and penetration is deep, highly efficient welding can be performed. The wire is supplied in precision layer winding on plastic spool.

## CHEMICAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cu
0.06 - 0.15	1.40 - 1.85	0.80 - 1.15	0.035 max	0.025 max	0.5 max

## MECHANICAL PROPERTIES (RANGE)

TS (N/mm <sup>2</sup> )	YS (N/mm <sup>2</sup> )	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
			-30°C	60 -90
540 min	430 min	28 min	-40°C	50 - 70

## TYPICAL APPLICATIONS

- Butt & fillet welding of steel structures such as vehicles, machinery & bridges etc.
- ASTM A210 GrAl, C, A36, A106GrA/B/C, A139, A214, A234
- Trailers, earth, moving equipments.
- Bus bodies, containers.
- Railway wagons, storage tanks.
- Ship building, pipe welding.
- The sheet welding in automotive industry.

## INSTRUCTION ON USAGE

- Use welding grade CO<sub>2</sub> / Argon + 15~25% CO<sub>2</sub> gas mixture.
- Flow quantity of shielding gas should be 25 l/min. approximately.
- Use wind screen against wind.
- Keep distance between tip and base metal 6~15mm for less than 250A, and 15~25mm for more than 250A of welding current.

## RECOMMENDED CURRENT (AMPS)

Size (mm)	F, HF	V up, OH
0.8	50 - 220	50 - 140
1.0	100 - 260	50 - 140
1.2	100 - 320	50 - 140
1.6	170 - 390	Not recommended

Size (mm)	Weight / Spool (kg)
0.8	15
1.0	15
1.2	15
1.6	15