GWELD
SEAL OF TRUST

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/mm2)	YS (N/mm2)	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 CO2 / Argon + 15~25% CO2 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

PACKING PARAMETERS

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