

GM 70N

CLASSIFICATION :

AWS/SFA 5.18: ER70S-6, JIS Z3312 YGW12, IS 814:2004

CHARACTERISTICS :

GM 70N 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 Composition of the Wire (%)

C	Mn	Si
0.06-0.15	1.40-1.85	0.80-1.15
S	P	Cu
0.012 max	0.015 max	0.5 max

Mechanical Properties of the All-Weld Metal

UTS (MPa)	YS (MPa)	ELN (%)	CVN Impact Value	
			Temp	Joules
490 min	400 min	22 min	-30°C	27min

TYPICAL APPLICATION :

- 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.

HARDNESS TEST AS PER NACE 0175 SPECIFICATION CORROSION TEST :

Recommended Current (Amps) :

Size (mm)	0.8mm	1.20mm	1.6mm
F, HF	50-220	100-320	170-390
V up, OH	50-140	50-140	Not recommended

PACKING DATA :

Size (mm)	Spool (Kgs.) (Nett Wt.)
0.6	15
0.8	15
1.2	15
1.6	15