

# 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) :**

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

**PACKING DATA :**

<b>Size (mm)</b>	<b>Spool (Kgs.) (Nett Wt.)</b>
0.6	15
0.8	15
1.2	15
1.6	15