

GM 70S3

IDENTIFICATION

GM 70S3, ER 70S3

CLASSIFICATION

AWS A-5.18: ER 70S-3

DESCRIPTION

Mild Steel Copper Coated mig wire suitable for Argon gas protective welding, with stable feasibility, good welding seams, less spatter and excellent welding process properties. Also used to weld high tensile steel at 490 MPa grade, high speed thin plate, usually used for steel 35, 45.

CHEMICAL ANALYSIS (RANGE) %

C	Mn	Si	Cu	S	P	Ni	Cr	Mo	V
0.06-0.12	0.90-1.40	0.45-0.75	0.5 Max	0.035 Max	0.025 Max	0.15 Max	0.15 Max	0.15 Max	0.03 Max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	ELN (%) (L=4D)	CVN Impact Value	
			Temp.	Joules
490 min	400 min	22 min	-30°C	≥27(-18)
			-20°C	≥30

TYPICAL APPLICATIONS

- For welding carbon steel tubes & plates such as A106 grade B etc.
- For welding of structural, pressure vessels and boilers involving unalloyed and micro alloyed structural steel with specified tensile strength upto 410-520 MPa.

SHIELDING GAS :Argon + 1-2% Oxygen or (Argon + 2-5% CO2)

PACKING PARAMETERS

Size (mm) Weight / Spool (kg)

0.8	12.5 / 15.0
1	12.5 / 15.0
1.2	12.5 / 15.0
1.6	12.5 / 15.0