

TAURUS MIG Wire 70S-6

TAURUS MIG WIRE 70S-6 is produced from high quality deoxidised rod. The products are copper coated for increased shelf life, which facilitates good electrical conductivity with reduced friction during high speed welding. **TAURUS MIG WIRE 70S-6** is a premium quality wire which is precision layer wound to provide positive uninterrupted feeding in semi-automatic and automated systems.

WELDING PROCEDURE

TAURUS MIG WIRE 70S-6 is suitable for dip (short arc), spray arc and pulsed arc transfer welding using CO₂ and Argon based shielding gases.



CLASSIFICATIONS			
AWS	A5.18	ER 70S-6	
SABS	145	Grade A	
EN ISO	14341	G42 2 C G4Si1	
EN ISO	636-A	W 42 3 W4Si1	
EN ISO	636-B	W 49 A 4 W4Si1	
APPROVALS			
TAURUS MIG WIRE 70S-6			
Lloyds Register of Shipping Grade DXVud, BF, 2S, 2YS, H15			
American Bureau of Shipping Grade 2SA			
TUV			
Typical Chemical Analysis (all weld metal)			
% Carbon	0.07 - 0.15	% Sulphur	0.035 max
% Manganese	1.4 - 1.85	% Phosphorous	0.03 max
% Silicon	0.8 - 1.15	% Copper	0.4 max (typical 0.18)
Typical Mechanical Properties (all weld metal in the as welded condition)			
TAURUS MIG WIRE 70S-6 with CO ₂ as Shielding Gas	As Welded	Stress Relieved 650°C/15 hr	Normalised 920°C/0.5 hr
0.2% Proof Stress	430 MPa min	360 MPa min	315 MPa min
Tensile strength	510 - 570 MPa	490 - 570 MPa	470 - 550 MPa
% Elongation on 50 mm	26 min	26 min	26 min
Charpy V-Notch at +20°C	110 J min	110 J min	80 J min
Charpy V-Notch at 0°C	80 J min	-	-
Charpy V-Notch at -20°C	47 J min	47 J min	47 J min
PACKING DATA			
Product Code	Description	Diameter (mm)	Pack mass (kg/spool)
0.6-5kg-M	TAURUS MIG WIRE 70S-SMALL SPOOL	0.6	5
0.8-5kg-M	TAURUS MIG WIRE 70S-SMALL SPOOL	0.8	5
0.8-M	TAURUS MIG WIRE 70S-6	0.8	15
0.9-M	TAURUS MIG WIRE 70S-6	0.9	15
1.0-M	TAURUS MIG WIRE 70S-6	1.0	15
1.2-M	TAURUS MIG WIRE 70S-6	1.2	15
1.6-M	TAURUS MIG WIRE 70S-6	1.6	15
The wire is layer wound onto plastic spools having a nominal mass of 15 kg.			