

TATA STEEL
#WeAlsoMakeTomorrow

TATA WIRON
#StrengtheningTomorrow

**PRECISION WELDING
STARTS WITH**

SPARK

MIG WELDING WIRE



"COPPER COATED C-Mn STEEL GMAW FILLER WIRE FOR HIGH TENSILE STRENGTH STEEL"

AWS A/SFA CLASSIFICATION: 5.18

ER 70S - 6

FEATURES

- C-Mn steel solid wire
- Radiographic quality weld
- Uniform copper coating
- Layer wound for smooth feeding
- Can be used with 100% CO₂ or 80% Ar/20% CO₂

APPLICATIONS

- Earth moving mining equipment, construction equipment, heavy fabrications, frame fabrications
- Thin sheet metal, auto body & components fabrications
- Robotic, Automatic and Semi-Automatic welding applications
- LPG Cylinder, Shaft, AXLE welding and General Fabrications

WELDING POSITION: 1F-1T

DCEP: ⚡

Shielding Gas	Gas Flow Rate LPM	Stick out in mm
100% CO ₂	14-18	10-20
80% Ar+20%CO ₂	17-22	10-20

MECHANICAL PROPERTIES OF ALL WELD METAL

Condition		Shielding Gas	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -30°C, J
Specifications	As Welded	100% CO ₂	500-640	420 min	22 min	47 min
Specifications	As Welded	80Ar + 20CO ₂	530-680	460 min	24 min	47 min

CHEMICAL COMPOSITION OF BARE SOLID WIRE, WT %

	C	Mn	Si	S	P	Cu*
Specifications	0.06-0.14	1.40-1.60	0.80-1.0	0.025 max	0.025 max	0.50 max

OPERATING PARAMETERS - PACKING DATA

Ø, mm	Voltage, V	Amperage, A	Net Wt. of Wire kg/Spool	MIGPAC DRUM, kg
0.80	22-26	180-220 Amps	12.5 / 15	250/450 kg
1.00	24-29	210-260 Amps	15	250/450 kg
1.20	26-31	260-290 Amps	15	250/450 kg
1.60	27-31	330-360 Amps	15	250/450 kg



HEAVY FABRICATION INDUSTRIES



EARTH MOVING EQUIPMENT MANUFACTURERS



AUTOMOTIVE INDUSTRIES



GENERAL FABRICATIONS

EFFECTIVE UTILIZATION OF MIG WELDING WIRE

- Ensure correct size contact tip is used
- Ensure that the liner of the welding gun is clean and free of copper flakes
- Ensure that wire feed setting is not too loose or tightly fitted
- Ensure that the flow of shielding gas is as per recommended parameters
- Clean the nozzle of the welding gun periodically, to remove spatter
- Cover the welding spool after use to prevent moisture and dirt pickup