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## 70S-6

# MILD STEEL MIG WIRE

### ◆ INTRODUCTION

AUFHAUSER E70S-6 contains high levels of manganese and silicon for stronger deoxidizing power where stringent cleaning procedures are not possible. The E70S-6 is intended for both single- and multiple-pass welding. This wire has been designed to provide X-ray quality porosity-free welds and the highest tensile strength (as welded) of the plain carbon steel wires. The high silicon content increases the fluidity of the weld pool, creating a smoother bead appearance and resulting in minimal post-weld grinding. AUFHAUSER 70S-6 is excellent where poor fit-ups or rusty and oily plates may be used. It is especially suited for sheet metal applications. These electrodes withstand high currents with CO<sub>2</sub> shielding, even when welding rimmed steels.

### ◆ APPLICATIONS

- Welding steels with dirty or rusty surface  
(UNS numbers K02600, K02801, K02001, K02700)
- Single-pass welding of killed, semi-killed, and rimmed steels, but may be used for some multi-pass applications.

### ◆ CHEMICAL COMPOSITION

(AWS A5.18, Typical)

	Carbon	Manganese	Silicon	Phosphorus	Sulfur
Nominal	.11	1.64	.86	.013	.010

Note: All values are maximum percentage, unless shown in range.



### ◆ PHYSICAL and MECHANICAL PROPERTIES

Tensile Strength:	81,000 psi
Yield:	67,900
Elongation, min. %:	29
Average Impact Strength%:	29

### ◆ SPECIFICATIONS MEET or EXCEED

- ANSI/AWS A5.18 (ER 70S6)

### ◆ STANDARD SIZES AND DIAMETERS

Diameters  
0.23", 0.30", 0.35", 0.45"

Properties were determined with 100% CO<sub>2</sub> shielding gas.