

ROMIG-70S6

COPPER COATED CONTINUOUS OR CUT LENGTH
SOLID WIRE FOR TIG/MIG WELDING

DIN 8559: SG2
BASIC ALLOY: FE, MN, SI
AWS: SFA/A 5.18: ER70S-6
EN ISO 14341-B G 49A 3 C/M S6

KEY FEATURES:

Copper coated double oxidized solid wire for all position CO2 welding. The special characteristics are smooth and stable arc low spatter Thin and uniform copper coating ensure good Conductivity useful for high speed feeding

APPLICATIONS

- structural steel& pipe welding
- sheet metal Carbon steel and low alloy steels

SHEILDING GAS:

- MIG welding with CO2 gas and Ar+ CO2 gas mixture, TIG welding with Argon gas

CHEMICAL COMPOSITION:

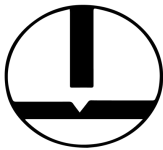
C	Mn	Si	S	P	Cu
0.06-0.15	1.40-1.85	0.80-1.15	0.035 Max	0.025 Max	0.50 Max

MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT @
420-480.	510-610	22-32	Minus 30C : 40-60 J

WELDING POSITION

1G/1F



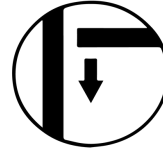
2G/2F



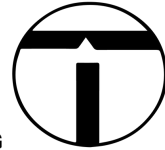
3G UP



3G DOWN



4G



DIEMENSION, CURRENT CONDITION & PACKING DATA (FOR MIG WELDING)

Size (mm)	Size (inch)	Current Condition (DC+)	Voltage (V)	Gas Flow Rate L/min	Spool packing 12.5 kg	Spool packing 15 kg	Drum packing 100/200kg
0.80	0.031	70-220	16-24	10-20	✓	✓	X
1.20	0.047	150-300	24-34	15-25	✓	✓	✓
1.60	1/16"	150-350	28-36	15-30	✓	✓	✓

DIEMENSION, CURRENT CONDITION & PACKING DATA (FOR TIG WELDING)

Size (mm)	Size (inch)	Length (mm)	Length (Inch)	Current Condition (DC-)	Voltage (V)	Tube packing 5 kg	Box packing 20 kg
1.60	1/ 16"	1000	36"	40-80	10-16	✓	✓
2.0	5/ 64"	1000	36"	50-100	12-18	✓	✓
2.4/ 2.5	3/ 32"	1000	36"	60-120	14-20	✓	✓
3.2	1/ 8"	1000	36"	100-150	16-24	✓	✓
4.0	5/ 32	1000	36"	140-200	18-28	✓	✓