

JACKSUN 70S - 6

MILD STEEL SOLID WIRE FOR MIG / MAG WELDING

GRADES

AWS/SFA 5.18 ER 70S - 6
IS 6419 S4-C 504

CHARACTERISTICS

Jacksun 70S-6 is a copper coated low alloy steel wire applicable for all position welding with CO₂ gas shield. This can be used with blend of argon / 5-20% CO₂ gas shielding also. The wire has a very good welding performance and the weld metal shows good impact toughness at lower temperature.

APPLICATIONS

Automobile Body, Chassis, Frames and Brackets
Automobile Silencers, Petrol/Diesel/Gas Tanks & all other
Automobile, Scooter, Cycle spare parts & accessories, LPG Gas
Cylinders, Compressors, Railway Wagons, Boilers, Poles & Steel
Towers. Steel furniture, Scaffoldings, Gratings & all other welding in
steel fabrication.

It is mainly for butt and fillet welding structures made by shipping
steels and low alloy steels such as ships, containers, vehicles,
engineering machinery construction equipment, mining equipment,
railway wagons and coaches, pipes, bridges and so on.

WELDING CURRENT SETTINGS AND PARAMETERS

| S.NO | SIZE IN MM | CURRENT (DC+) AMPS | CURRENT (DC+) VOLTS | GAS FLOW L/M |
|------|------------|--------------------|---------------------|--------------|
| 1 | 0.60 | 50 - 150 | 18 - 25 | 10 - 25 |
| 2 | 0.80 | 50 - 180 | 18 - 25 | 10 - 25 |
| 3 | 0.90 | 80 - 200 | 18 - 25 | 10 - 25 |
| 4 | 1.00 | 80 - 200 | 20 - 26 | 12 - 20 |
| 5 | 1.20 | 130 - 300 | 22 - 36 | 15 - 25 |
| 6 | 1.60 | 200 - 400 | 24 - 38 | 16 - 28 |

MECHANICAL PROPERTIES OF WELD METAL

| U.T.S (N/mm ²) | Y.S (N/mm ²) | ELONGATION (L=4d)% | IMPACT (CVN) AT - 30° C) |
|----------------------------|--------------------------|--------------------|--------------------------|
| 400 MIN | 480 MIN | 22 MIN | 27 MIN |

WIRE CHEMISTRY

CARBON - 0.06 - 0.15%

MANGANESE - 1.40 - 1.85%

SILICON - 0.80 - 1.15%

PHOSPHORUS - 0.025 MAX

SULFUR - 0.035 MAX

COPPER - 0.50 MAX

PACKAGING

100% Precision Layer Winded in Plastic Spools

5 Kg / 12.5 Kg / 15 Kg

Fiber Drum Pack: 100 Kgs / 250 Kgs

SIZES (MM)

0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60, 2.00

CONTACT

ROYAL WELDING WIRES PRIVATE LIMITED

An ISO 9001 - 2008 Certified Company

No. 7 Karanai Puducheri Village, (Via) Urapakkam - 603 202.

Kanchipuram Dist. Tamilnadu

Ph.: +91 9500055940 / 9500033041

E-mail : admin@theroyalfirm.in Web : www.theroyalfirm.in