



AUSTFIL 70C-6M



- ▶ Gas Shielded, Metal-Cored Wire
- ▶ Slag-Free Weld Bead
- ▶ Higher Deposition Rates
- ▶ Low Spatter / Smooth Appearance
- ▶ Better Fusion Than Solid Wire.

Classifications

AS/NZS 2203.1 ETD*-GMp_W503A.CM1H10 (superseded).

AS/NZS ISO 17632 BT 49 2 T15 O M A U H10**

AWS A5.18 E70C-6M

*1.2mm can be used in some positional applications

**New Classification replaces AS/NZS 2203.1

Description & Applications

Austfil 70C-6M is a metal-cored wire designed for high speed fillet and butt welding in the downhand position using Argon + 18-25% CO₂ shielding gas mixture. Weld beads are almost completely slag free with only minimal silicon islands, reducing the time and effort spent between runs and on cleanup prior to surface finishing.

Austfil 70C-6M is recommended for single and multi pass welding in both flat and horizontal positions for mild steel, carbon and manganese carbon steels with minimum clean up and where high deposition rates and efficiencies are required in high productivity, semi automatic and fully automatic welding installations. Suitable applications include mining buckets, structural fabrication and tank construction where high speed welding is required.

Operational Data

WIRE SIZE (mm)	WELDING CURRENT RANGE (amps)	ARC VOLTAGE RANGE (volts)*
1.2	200 - 350	29 - 35
1.6	300 - 450	27 - 34

Welding Current DC+

* Voltage is determined by arc current and wire arc length. Welding currents and voltage shown are operational guides only.

Shipping Approvals

LRS 3S, 3YS

Typical All Weld Metal Chemical Analysis

C	Mn	Si	S	P
0.038	1.46	0.68	0.009	0.012

Cr	Ni	Mo	V	Cu
0.01	0.02	0.00	0.01	0.02

Typical All Weld Metal Mechanical Properties

Gas Type	Ar+25% CO ₂
Yield Stress	587 Mpa
Tensile Strength	628 Mpa
Elongation	29%
CVN Impact Values	51J @ -29°C
Diffusible Hydrogen	H10 - 7.0ml avg/100g of deposited weld metal.

Packaging Data

WIRE SIZE (mm)	PACK SIZE (kg)	PART NUMBER
1.2	15	70C6M12S
1.6	15	70C6M16S

Storage Information

Products should be stored in dry conditions in original sealed undamaged packaging as supplied. The integrity of consumable products can be adversely affected by time and storage conditions and that the detail shown in the batch certificate is true at the time of packaging and is only valid for a LIMITED time. After that time the product may need to be reconditioned or checked to ensure it is suitable for the purpose it is intended to be used for.*

Wire should be stored in a plastic bag when not in use for extended periods. Recommended conditions of storage are minimum temperature of 15°C and humidity of 60% RH.

*NOTE: Refer to Welding Technology Institute of Australia (WTIA), technical 3. care and conditioning of arc welding consumables.

Issue AB

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