

Mig/Mag Strongweld WIRE AWS ER 70S - 6

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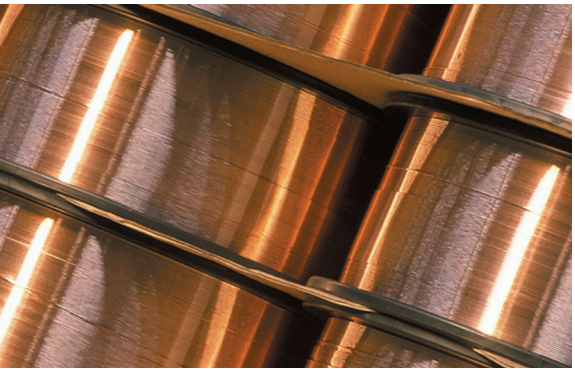
Packaing of Strongweld Solid Welding Wire

Strongweld wire manufactured under Solcon Process ISO 9001, comes in three packages 33 lb plastic spools, 600 lb Mig Matic drums, and 11 lb Spools.

Package	Packaging	Sizes of Package (inches)	Pallet
11 lb. (5 kg)			
Randon rolled Plastic Spool	Plastic Bag Green box	Flange Diameter: 8 Widht : 2,16 Arbor hole: 2,03	Units: 1 master/ 4 Spool 48 Master/Pallet Weight: 2,112 lb net Large: 38" Widht: 50" Height: 36"
33 lb. (15 kg)			
Precision rolled Plastic Spool	Plastic bag Green box	Flange Diameter: 12 Widht : 4 Arbor hole: 2,03	Units: 63 boxes/pallet Weight: 2,079 lb net Large: 38" Widht: 38" Height: 38"
600 lb. (272 kg)			
Mig Mag Drum	Green Drums	Outer Diameter: 20,3 Height: 30,7	Units: 4 Drums/pallet Weight: 2,400 lb net Large: 43" Widht: 43" Height: 37"

Logistic

Strongweld warehouse is strategically located to offer optimum delivery times and minimum transportation cost. With Indura concentrating on timely and cost - efficient distribution, our customers are free to focus their time, capital and human resources on their core business and the things they do best.



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www.strongweld.net
360 Grand Cypress - #301
Palmdale, CA 93551
661-274-0584



Random rolled plastic spool 11 lb.

Precision rolled plastic spool 33 lb.

Mig Matic 600 lb drum.

Higher productivity
Smooth Arc
Balanced Helix
Higher Manganese & Silicon
ISO 9001

Strongweld®
Ultimate Welding Performance



INDURA Certificada
ISO 9001



Strongweld®
Ultimate Welding Performance

Strongweld ER70S-6

Wire elaborated under ISO 9001 process, is a mild steel electrode, coated with copper-plated, that offers an excellent weldability when it's used with CO₂ or Ar/CO₂ mixtures.

The Strongweld wire contain higher manganese and silicon levels, which provide higher deposit strengths and better de-oxidation characteristic, specially when welding over rusty, scaly or oily surfaces or when welding rimmed steels.

Its adicional silicon produces a more fluid puddle and, therefore, a flatter bead. This characteristic is useful on sheet metal welding with dip- transfer, where a minimun amount of build up and post welding grinding is required. Another characteristic of Strongweld wire is its exceptionally smooth arc and low spatter level particurly in the dip transfer mode.

Strongweld wire has been developed to ensure sound, porosity- free weld and scar that contributes to reduce the cleaning operation.

The carefully balanced helix. allows a perfect feeding. Precision rolled allows a higher productivty and less friction in the conduits, which minimize flaking problems.

Typical applications:

- Ideal for robotic applications
- Structural and mild steel welding
- Construction of heavy equipment
- Shaft buildup
- Pressure tanks
- Truck bodies
- Farm equipment fabrication
- Automotive Industry application
- Furniture manufacture
- General shop work

Conformances:

- AWS A5. 18, class ER70S-6
- ASME IIC SFA 5.18, F-6, A-1

Annually approved by:

- American bureau of Shipping
- Lloyd`s Registred of Shipping
- Bureau Veritas
- Germanischer Lloyd
- Det Norske Veritas
- Canadian Welding Bureau



Typical Wire Chemistry

Strongweld	INDURA (as manufactured)	AWS Spec
Carbon	0,09%	0,06/0,15
Manganese	1,45%	1,40/1,85
Silicon	0,95%	0,80/1,15
Phosphorus	<0,02%	0,025 max
Sulphur	<0,02%	0,035 max

Typical Weld Metal Propierties (Chem Pad)

Gas applied (100% CO ₂)	Gas applied (75 arc - 25% CO ₂)	Gas applied (75 arc - 25% CO ₂)
0.09%	0.10%	0.10%
0.80%	0.81%	0.82%
0.57%	0.60%	0.62%
0.01%	0.01%	0.01%
< 0.02%	< 0.02 %	0.01%

Typical mechanical propierties (AWS: A5.18-01)

Strongweld	Measure	INDURA wire gas applied 100% CO ₂	INDURA wire gas applied 75% Ar - 25 %CO ₂	INDURA wire gas applied 80% Ar - 20%CO ₂	AWS spec gas applied 100% CO ₂
Tensile Strength	Psi	76,800	77,800	78,900	70,000
Yiel Strength	Psi	62,100	63.500	64.300	58.000
Elongation	% in 2"	28%	31%	32.8%	22% min

Typical Charpy V-notch impact values

Strongweld	Measure	INDURA wire 100% CO ₂	INDURA wire 75% Ar - 25 %CO ₂	INDURA wire 80% Ar - 20%CO ₂	AWS spec 100% CO ₂
at -20F	Joule	50,2 ²	54,0	56,4	27 min.

Welding Parameters and Data

Electrode diameter Inches (mm)	Material thickness Inches (mm)	Welding current (Amps)	Voltage (Volts)	Wire Feed (Inch/min)	Gas Flow (gal/min)
0,030 (0,8)	0,025 (0,6)	30-50	16-17	50-70	1,80 - 2,20
	0,030 (0,8)	35-60	16-17,5	50-80	1,85 - 2,40
	0,036 (0,9)	40-70	17-18	60-120	2,00 - 2,40
0,035 (0,9)	0,050 (1,3)	70-90	18-19	120-140	2,10 - 2,40
	1/16 (1,6)	80-110	19-20	130-150	2,30 - 2,90
	5/64 (2,0)	120-130	20-21	140-160	2,40 - 3,17
0,045 (1,1) 0.052 (1.3)	1/8 (3,2)	120 - 180	20-22	120-240	2,40 - 3,43
	3/16 (4,7)	160 - 180	21-22	200-240	3,17 - 3,70
	1/4 (6,4)	190 - 200	22-23	250-280	3,17 - 3,70
	0.31 (7.9)	200 - 210	23-24	275-290	3,17 - 3,70
	0.37 (9.4)	220 - 250	24-25	295-350	3,17 - 3,70
	1/2 (12.7)	240 - 260	28-29	330-375	3,17 - 3,70
	3/4 (19.0)	280 - 300	30-32	180-200	3.70 - 4.23

