

SUPERGLIDE® S6

Mild Steel, Non-Copper Coated Wire ■ AWS ER70S-6

KEY FEATURES

- High levels of manganese and silicon deoxidizers tolerate medium to heavy mill scale surfaces
- MicroGuard® Ultra provides superior feeding and arc stability
- Supports short-circuiting, globular, axial spray and pulsed spray transfer
- Non-copper coated

WELDING POSITIONS

All

SHIELDING GAS

100% CO₂
 75-95% Argon / Balance CO₂
 95-98% Argon / Balance O₂
 Flow Rate: 30 - 50 CFH

CONFORMANCES

AWS A5.18/A5.18M:	ER70S-6
ASME SFA-A5.18:	ER70S-6
CWB/CSA W48-06:	ER49S-6
EN ISO 14341-B:	G 49A 3 C S6
MIL-E-23765/1:	MIL-70S-6

TYPICAL APPLICATIONS

- Medium to heavy mill scale base material
- Sheet metal to 380 - 485 MPa (55 - 70 ksi) yield strength material
- Automotive repair

DIAMETERS / PACKAGING

Diameter in (mm)	44 lb (20 kg) Fiber Spool	500 lb (227 kg) Accu-Trak® Drum	900 lb (408 kg) Accu-Trak® Drum
0.035 (0.9)	ED028635		ED034560
0.045 (1.1)	ED028636	ED030695	ED034561

MECHANICAL PROPERTIES⁽¹⁾ – As Required per AWS A5.18/A5.18M

	Yield Strength ⁽²⁾ MPa (ksi)	Tensile Strength MPa (ksi)	Elongation %	Charpy V-Notch J (ft·lbf) @ -29° C (-20° F)
Requirements⁽⁴⁾ - AWS ER70S-6 As-Welded with 100% CO ₂	400 (58) min	485 (70) min	22 min	27 (20) min
Typical Results⁽³⁾ - As-Welded with 100% CO ₂	430 (62)	540 (78)	28	71 (52)

⁽¹⁾Typical all weld metal. ⁽²⁾Measured with 0.2% offset. ⁽³⁾See test results disclaimer ⁽⁴⁾CTWD (Contact Tip to Work Distance). Subtract 1/4 in (6.4 mm) to calculate Electrical Stickout.