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

<table>
<thead>
<tr>
<th>Diameter in (mm)</th>
<th>44 lb (20 kg) Fiber Spool</th>
<th>500 lb (227 kg) Accu-Trak® Drum</th>
<th>900 lb (408 kg) Accu-Trak® Drum</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.035 (0.9)</td>
<td>ED028635</td>
<td>ED030695</td>
<td>ED034560</td>
</tr>
<tr>
<td>0.045 (1.1)</td>
<td>ED028636</td>
<td></td>
<td>ED034561</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Requirements(4) - AWS ER70S-6 As-Welded with 100% CO₂</th>
<th>Yield Strength(2) MPa (ksi)</th>
<th>Tensile Strength MPa (ksi)</th>
<th>Elongation %</th>
<th>Charpy V-Notch J (ft•lb) @ -29°C (-20°F)</th>
</tr>
</thead>
<tbody>
<tr>
<td>400 (58) min</td>
<td>485 (70) min</td>
<td>22 min</td>
<td>27 (20) min</td>
<td></td>
</tr>
</tbody>
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Typical Results(3) - As-Welded with 100% CO₂

| 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.