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INTRODUCTION

Eurekamatic ER70S-6 Wire was developed for the joining and heavy build up of low alloy and mild steels. This fully deoxidized filler metal yields dense porous free weld deposits.

METALLURGICAL CHARACTERISTICS

All weld metal deposits display approximately 70,000 P.S.I. tensile strength with 25% elongation.

RECOMMENDED APPLICATIONS

Eurekamatic ER70S-6 Solid Wire can be used for general repair or fabrication of low alloy and mild steels and for use as an underlay prior to the deposition of a hard facing alloy.

PREPARATION AND WELDING PROCEDURES

- The area to be welded must be free of scale, dirt, oil, etc.
- Remove all cracked, worn, and fatigued metal.
- Preheat according to base metal.
- Select the G.M.A.W. process. Use D.C.R.P. current and 75% Argon, 25% Carbon Dioxide shielding gas with a flow rate of 25 - 35 C.F.H. Short Circuit transfer for .045" diameter, 16 - 18 volts, 120 - 160 amps.