

## Product: AWS ER70S-6

### 1. Diameter:

0.8mm, 0.9mm, 1.0mm, 1.2mm, 1.6mm, 2.0mm

### 2. Weight:

5kg, 15kg, 20kg/spool,  
250kg, 350kg/drum

### 3. Package:

White or Black spool; or one meter long straight barrel, Basketry, Drum

### 4. Certificates:

ISO, CE, ABS, TUV, DB, CCS, LR, NK, BV, GL etc

### 5. Material:

Mild/Carbon steel, Copper coated,  
CO2 or Ar protection when welding



### 6. Confirm with:

GB/T 8110-2008 ER50-6    **DIN 8559 SG2**  
AWS A5.18 ER70S-6        **EN 440 G3Si1**  
JIS YGW12                    **BS A18**

### 7. Applications:

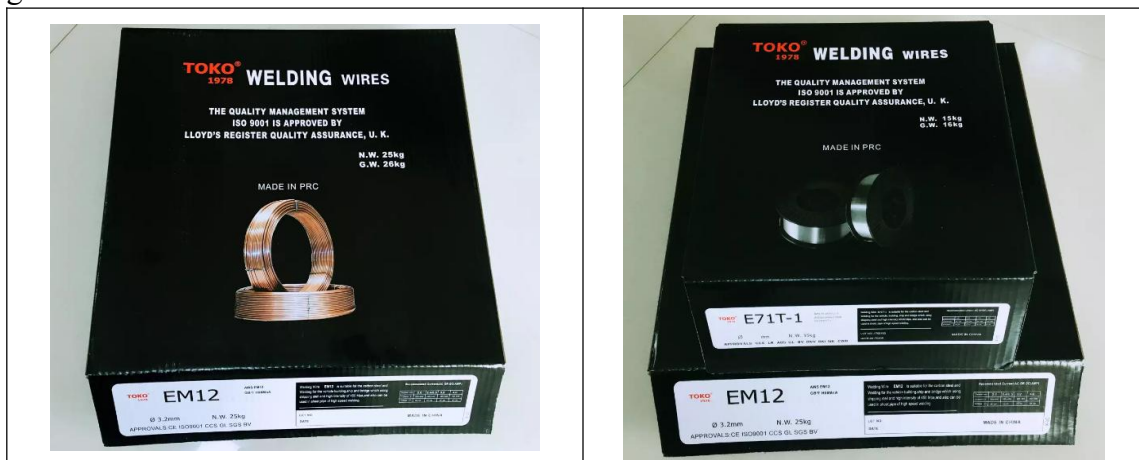
Automobile Body, Chassis, Frames and  
Brackets

Automobile, Scooter, Cycle spare parts &  
accessories

LPG Gas Cylinders, Compressors, Railway  
Wagons, Boilers, Poles & Steel Towers.

Steel furniture, scaffolding & all other welding in

general steel fabrication



TOKO 焊材—業界の将来をリードする!

TOKO WELDING—To Lead The Future of The Industry!

Website: <http://www.tokoc.com>

Email: [office@tokoc.com](mailto:office@tokoc.com)

Fax: (86)510-8359 7138

## Welding Information

AWS A5.18/A5.18M ER70S-6										
Chemical Compositions (%):										
Items	C	Mn	Si	P	S	Ni	Cr	Mo	Cu	V
Standard	0.06~0.15	1.4~1.85	0.8~1.15	≤0.025	≤0.035	≤0.15			≤0.50	≤0.03
Actual	0.08	1.51	0.89	0.015	0.013	0.016	0.021	0.006	0.18	0.003
Mechanical Performance:										
Tensile strength Rm (Mpa)	Yield Strength Rel or Rp0.2 (Mpa)		Elongation Ratio(%)			Fracture Energy (J)		Protection Gas		
545	452		29			91 (-30℃)		CO <sub>2</sub> 、Ar		

### Welding Technology:

1. Shielded gas: CO<sub>2</sub>(Purity≥99.5%), or 80%Ar+20%CO<sub>2</sub>
2. Reference welding Curreent and Voltage

Size (mm)	Current (Amp)	Reference Current	Voltage (V)	Packing in KGS	
				15, 20	250
0.8	50~120	100	15~22	√	√
1.0	70~180	150	18~24	√	√
1.2	80~350	280	18~34	√	√
1.6	140~500	350	20~42	√	√



D270,D300,K300 Packing: 1 pallet,6 layers of 12, 72x 15kg spools-1080kg.

TOKO 焊材—業界の将来をリードする!

TOKO WELDING—To Lead The Future of The Industry!

Website: <http://www.tokoc.com>

Email: [office@tokoc.com](mailto:office@tokoc.com)

Fax: (86)510-8359 7138

For D270, it can hold 24.84Metric Ton/Container.

For D300,K300, it can hold 21.6 Metric Ton/Container



TOKO 焊材—業界の将来をリードする!

TOKO WELDING—To Lead The Future of The Industry!

Website: <http://www.tokoc.com>

Email: [office@tokoc.com](mailto:office@tokoc.com)

Fax: (86)510-8359 7138



Drum Packing: 250kg/Drum, Drum Size: 550mm\*810mm (Height) 4drum/pallet  
It can hold 22 Metric Ton of drum packing welding wire in 20" Container



Drum Packing: 350kg/Drum, Drum Size:660\*810mm(Height)