

# TALWELD S6

## CLASSIFICATION

AWS SPECIFICATIONS	EN SPECIFICATIONS
AWS A 5.18: ER70S-6	EN ISO 14341-A: G 46 4 M G3Si1
	EN ISO 14341-A: G 42 2 C G3Si1

## ALLOY TYPE

Copper-coated solid wire for welding carbon and C-Mn steels with tensile strength up to 510 MPa.

## APPLICATIONS

Copper-coated solid wire designed for welding carbon and carbon-manganese steels with tensile strength up to 510 MPa. Suitable for single pass or multi-pass welding. Applications include tanks, boilers, steel structural works, earthworks and construction works. To be used under the shield of Ar+CO<sub>2</sub> or CO<sub>2</sub>.

## TYPICAL CHEMICAL COMPOSITION OF WIRE

C %	Mn %	Si %	S %	P %	Cu %	Ni %	Cr %	Mo %
0.07	1.40	0.80	0.012	0.012	0.15	-	-	-

## TYPICAL MECHANICAL PROPERTIES

GAS		Yield strength	Tensile strength	Elongation on % 5d	Impact energy (Charpy V)				
		Rs	Rm	A 5d	+ 20°C	0°C	-20°C	-40°C	-60°C
		(MPa)	(MPa)	%	(Joule)	(Joule)	(Joule)	(Joule)	(Joule)
MIX	as welded	470	560	26	150	-	90	60	-

## WELDING GUIDELINES

Preheat and PWHT are not required.

## TECHNICAL INFORMATION

Gas: CO<sub>2</sub> & Mix Ar- CO<sub>2</sub> (EN ISO 14175)

Welding position: all positions



## WELDING PARAMETERS

Current	DC + Reverse polarity		
Diameter (mm)	0.6	0.8	
Volts (V)	12-18	16-28	
Intensity (A)	35-110	60-200	

Diam.	0.9 kg Spool	5 kg Spool	15 kg Spool
0.6mm	INMS60609	INMS60605	INMS60615
0.8mm	INMS60809		

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