



## SUNMIG S-6

### CLASSIFICATION:

AWS5.1: ER 70 S-6

### DESCRIPTION:

SUNMIG S-6 is copper coated manganese – silicon bearing wire for GMAW using CO<sub>2</sub> or 80% Ar, 20% CO<sub>2</sub> mixtures for shielding. SUNMIG S-6 is designed for all positional welding of Sheet metal, carbon steels & low alloy steels including structural steel with a tensile strength of 540 n/mm<sup>2</sup>.

**APPROVALS:** NHECL,CEBBCO

### TYPICAL ALL WELD METAL PROPERTIES:

Chemical Composition (%)				Mechanical Properties	
C	0.08	Mn	1.45	YS	44 Kg/mm <sup>2</sup>
Si	0.85			UTS	520 Kg/mm <sup>2</sup>
				EL (L-4d)	30%
				Impact (CVN) at -29° C	27 J

### TYPICAL APPLICATIONS:

Mild Steel Structures, rail coaches, wagons, storage tanks etc.

### CURRENT RANGE & PACKING DATA:

Size	Current Range	Packaging Per	Winding
(mm)	(Amps)	Carton	
0.8	60-220	15 Kg	PLW
1.00	80-250	15 Kg	PLW
1.20	120-280	15 Kg	PLW
1.60	200-400	15 Kg	PLW

### PACKING:

The wires are supplied in Plastic Spools weight 15 Kg Per Spool packed in a Cardboard box.