



# AUTOMIG MC 70C-6C

MCAW C-Mn STEEL



METAL CORED WIRE FOR MIG / MAG WELDING

<b>CLASSIFICATION :</b> AWS A/SFA 5.18	AWS A/SFA 5.36	<b>APPROVALS:</b>
E70C-6CH4	E70T15-C1A2-CS1-H4	-

## KEY FEATURES :

- Metal cored wire suitable with CO<sub>2</sub> shielding gas
- Good weldability, minimal or no slag
- Excellent bead appearance
- Exceptional mechanical properties at low temperatures
- High deposition rate
- Suitable for single and multi pass welding
- Best suited for automated and robotized applications

<b>WELDING POSITION :</b>			<b>DCEP</b>
<b>Shielding Gas</b>	<b>Gas Flow Rate, LPM</b>	<b>Stickout, mm</b>	
100% CO <sub>2</sub>	14-20	15-25	

## TYPICAL APPLICATIONS :

- Welding of Carbon, C-Mn and similar types including fine grained steels
- Ship building, Boilers
- Suitable for joining SA 36/36M (P.No.1), SA 285/285M Gr.A/B/C (P.No.1)
- Pressure Vessels, Pipe steels

## STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

## CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt% :

	<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>S</b>	<b>P</b>
Typical	0.06	1.4	0.6	0.01	0.01
Specification	0.12 max	1.75 max	0.90 max	0.03 Max	0.03 Max

## MECHANICAL PROPERTIES OF ALL WELD METAL :

	<b>Condition</b>	<b>UTS, MPa</b>	<b>YS at 0.2% offset, MPa</b>	<b>EL%</b>	<b>CVN Impact at -30°C, J</b>
Typical	As Welded	550	500	28	72
Specification		480 min	400 min	22 min	27 min

Diffusible H<sub>2</sub> Content: <4 ml/100 gm

## PARAMETERS - PACKING DATA :

<b>Ø, mm</b>	<b>Voltage, V</b>	<b>Amperage, A</b>	<b>Kg/Spool</b>
1.2	24-30	120-350	15
1.6	26-32	180 - 400	15

