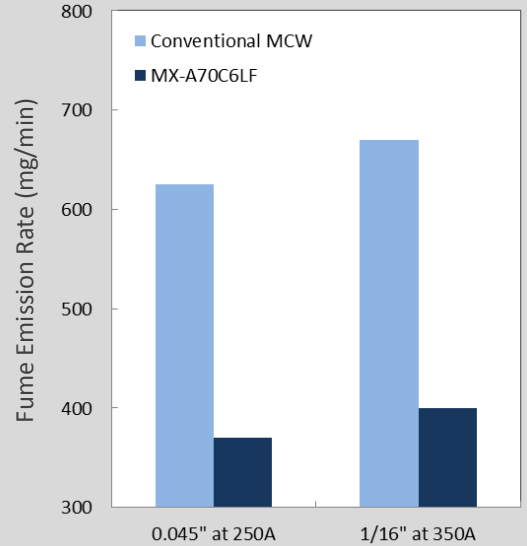




Mild Steel Metal Cored Wire
 AWS A5.18 E70C-6M
 CWB CSA W48-06 E492C-6M-H4

Features and typical fields of application

- MX-A70C6LF is a 70ksi class mild steel metal cored wire for flat and horizontal welding with 75-95%Ar-bal. CO₂ mixed gas.
- Its low fume emission, minimized spatter generation formula creates a clean welding environment at any welding condition than our conventional metal cored wire, MX-A70C6. This is the simple reason why this newly developed metal cored wire is named with “LF” which stands for Low Fume.



Typical chemical composition of weld metal in 1/16" wire diameter

Shielding Gas	C	Si	Mn	P	S	Diffusible Hydrogen Content (mL/100g)
80%Ar-20%CO ₂	0.04	0.79	1.62	0.008	0.009	2.9
95%Ar-5%CO ₂	0.04	0.85	1.69	0.007	0.010	3.5

Gas chromatography method (AWS A4.3)

Typical mechanical property of weld metal in 1/16" wire diameter

Shielding Gas	0.2% PS (psi)	TS (psi)	EL (%)	CVN at -20F° (ft-Lbs)
80%Ar-20%CO ₂	64,700	80,400	34	96
95%Ar-5%CO ₂	66,600	81,900	34	101

Approvals

CWB



Mild Steel Metal Cored Wire
 AWS A5.18 E70C-6M
 CWB CSA W48-06 E492C-6M-H4

Recommended welding conditions and deposition rate

Wire Dia.	Wire Feed Speed (in./min)	Current (A)	Arc Voltage (V)	Deposition Rate (Lbs/hr)	Wire Stick-Out	Shielding Gas flow rate (CFH)
0.045"	300	200	28-31	7.5	5/8-3/4"	40-50
	375	240	29-33	9.5		
	435	280	30-34	11.0		
	530	320	32-34	13.5		
	620	360	33-37	15.5		
0.052"	250	230	27-29	8.5	3/4-1"	40-50
	300	270	28-32	10.5		
	400	320	30-34	14.0		
	460	370	31-36	16.0		
	545	420	32-37	19.0		
1/16"	165	260	27-29	7.5	3/4-1"	40-50
	245	320	28-33	11.5		
	350	380	29-35	17.0		
	415	440	30-36	20.0		
	490	500	31-37	24.0		

Table shown are approximate values that will vary depending on welding conditions (WESO, Cable length etc.).

Available Products

Wire Dia.	0.045", 0.052", 1/16"	Package	44Lbs spool , 550Lbs drum
-----------	-----------------------	---------	---------------------------

DISCLAIMER

- Information in this material, such as chemical compositions and mechanical properties, is typical or an example for explaining the features and performances of our products, and it does not mean guarantee unless otherwise it is specified.
- Information contained herein is subject to change without notice. Please kindly contact Kobelco for latest information.



WARNING: This product can expose you to chemicals including Nickel and Titanium Dioxide, which are known to the State of California to cause cancer, and Chromium, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to www.P65Warnings.ca.gov.

KOBELCO WELDING OF AMERICA INC.



4755 Alpine Drive, Suite 250, Stafford, Texas 77477
 TEL: 281-240-5600 TOLL-FREE: 800-961-3158 FAX: 281-240-5625
<http://www.kobelcowelding.com>