

# NB-70S-6 MAG Welding wire

## 1. Classifications:

AWS A5.18: ER 70S-6; JIS Z 3312: YGW12;  
Approved by Vietnam Register :TCVN 6259-6 /SW53.

## 2. Size, recommended currents and gas flow:

Dia (mm)	Φ0.8	Φ0.9	Φ1.0	Φ1.2	Φ1.6
Current (A)	80 ÷120	90÷130	100 ÷140	110 ÷200	180 ÷320
Voltage (V)	20 ÷ 21	20 ÷22	22 ÷ 24	23 ÷25	25 ÷28
Gas flow (l/min)	8 ÷ 9	9 ÷ 10	10 ÷ 11	12 ÷ 13	16 ÷ 18

## 3. Mechanical properties of the weld metal:

Yield point (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact value (J/ 0°C )	Shielded Gas
≥ 420	≥ 510	≥ 22	≥ 50	CO <sub>2</sub>
≥ 430	≥ 520	≥ 24	≥ 60	80%Ar + 20%CO <sub>2</sub>

## 4. Chemical compositions of the weld metal:

%C	%Mn	%Si	%S	%P
0.05 ÷ 0.12	1.0 ÷ 1.85	0.40 ÷ 1.15	≤ 0.030	≤ 0.030

## 5. Applications:

NB-70S-6 is suitable for welding structure of the carbon and low-alloy steel and steel structure with steel strength more than 500 N/mm<sup>2</sup> such as pressure tanks, automotive vehicles, ships, bridges, engineering constructions and containers, etc. It also can be used for thin plates, pipeline with high welding speed.



### Importer:



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