

# MOHINDERZ MIG / MAG

(Confirming to)

ER - 70S - 6, AWS - 5.18

IS: 6419-1996 : DIN - 8559



## Mild Steel Electrodes for General Purpose Structural, Engineering & Fabrication Welding Application

### FEATURES

|   |   |
|---|---|
| Deoxidized Copper coated Electrode                | Shielding Gas - CO <sub>2</sub> or Ar ( 20% ) CO <sub>2</sub> Mixture |
| Continuous feed, full penetration & Metal deposit | X - Ray quality Weld profile  |
| Very Low wastage, low spatter                     | Smooth and consistent finish  |
| Low Hydrogen type                                 | All Position Welding  |

### APPLICATIONS

Steel Structure / Storage & Pressure Vessels / Pipes / Sheet Metal / Automobile Body / Ship building & Railways / Industrial Engineering & Machinery / General Fabrication

### CHEMICAL COMPOSITION OF WELD METAL (Weight %)

| Cu       | Mn        | Si        | C        | S         | P         |
|----------|-----------|-----------|----------|-----------|-----------|
| 0.50 Max | 1.40-1.85 | 0.80-1.15 | 07-0.150 | 0.035 Max | 0.025 Max |

### MECHANICAL PROPERTIES OF WELD METAL

| Property      | Metal Condition | UTS (Mpa) | YS at 0.2% (Mpa) | EL % (L = 5D) | CVN Impact at 0°C |
|---------------|-----------------|-----------|------------------|---------------|-------------------|
| Specification | As Welded       | 500-640   | 420-450          | 22 Min        | 70 J Min          |

### PACKING & WELDING DATA

| Size (Dia mm) | Spool Size     | Current (Amp) | Packing  | Standard Wt/ spool |
|---------------|----------------|---------------|--|--------------------|
| 0.8           | 300D x 100 mmW | 60 - 220      | Packed in anti-corrosive paper / polythene / shrink wrapped. Spool then packed in Cardboard Box. | 12.5/13.5/15 kg    |
| 1             | 300D x 100 mmW | 80 - 280      |  | 12.5/13.5/15 kg    |
| 1.2           | 300D x 100 mmW | 90 - 330      |  | 12.5/13.5/15 kg    |

12.5 kg packing is with random winding / 13.5 kg & 15 kg packing is with Layer winding



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## MOHINDER ELECTRODES PVT. LTD.

(Mfrs. & Exporters of Electrodes & MIG Wire)

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