NATIONAL STANDARD

Because performance comes down to the wire.

NS-115 CopperFree™ AWS ER70S-6

DESCRIPTION

NS-115 CopperFree™ is a mild steel solid filler wire containing a high combined total of manganese and silicon. The wire produces a smooth, uniform welding arc, which minimizes weld spatter and results in excellent bead appearance and high operator appeal. The excellent operating characteristics of NS-115 appeal to users seeking better performance in their ER70S-6 applications.

CHARACTERISTICS

NS-115 CopperFree™ provides the ultimate in flexibility to support your GMAW operations.

- Cast of 35" (.88m) to 55" (1.3m) and Helix below 1" (25.4mm) improve feedabiltiy and provide accurate wire positioining
- Higher Silicon content reduces the molten metal surface tension, resulting in flatter bead profiles
- Manufactured according to ISO9001:2008 quality standards
- Excellent arc starts, arc stability and feedability
- Minimal spatter
- No copper flaking
- High level de-oxidizers
- Excellent weld appearance and post weld cleaning

PRODUCED IN: Stillwater, Oklahoma

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SPECIFICATIONS

Meets or exceeds:

- AWS A5.18: ER70S-6 H4, AWS A5.18M: ER48S-6
- ASME SFA-5.18: ER70S-6
- AWS A5.17: EH11K (1/16" dia. only)
- ABS

APPLICATIONS

Well-suited for these applications:

- All metal transfer modes of GMAW
- Robotic, mechanized or semi-automatic welding
- Welding steel with medium to heavy mill scale, light rust or thin oil
- Single and multi-pass weldments
- Applications requiring a minimum 70,000 psi tensile strength

SHIELDING GAS BLENDS

Typical Application Sheilding Gas Blends:

- 100% CO2
- 75-95% Argon/Balance CO2
- 95-98% Argon/Balance O2
- Flow Rate: 35-50 CFH

WELDING POSITIONS

All position welding is possible when using the correct shielding gas blends, welding process and welding parameters.

STORAGE

Welding wire should be stored in a dry, enclosed environment and in its originally-sealed package.

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