



MILD STEEL / LOW ALLOY

ER70S-2 (GTAW) TIG

A premium, multiple deoxidized, wire. Produces high quality welds in most grades of carbon steels. ER70S-2 is a triple deoxidized wire which provides defect free weld deposits when properly used on most carbon steels. It is used especially for pipe welding. ER70S-2 Conforms to AWS A5.18 ER70S-2



PN: E70S2605POP
1/8" x 36" - 5# PKG

Chemical Composition		
C-.15%	Mn-0.90-1.40%	Si-0.45-0.70%
S-0.035%	P-0.025%	Ti-0.05-0.15%
Zr-0.02-0.12%	Al-0.05-0.15%	

PART NO.	SIZE
E70S2F0	.035" x 36" - 10# PKG
E70S2H0	.045" x 36" - 10# PKG
E70S230	1/16" x 36" - 10# PKG
E70S250	3/32" x 36" - 10# PKG
E70S260	1/8" x 36" - 10# PKG
E70S270	5/32" x 36" - 10# PKG
E70S2300POP	1/16" x 36" - 1# PKG
E70S2303POP	1/16" x 36" - 3# PKG
E70S2305POP	1/16" x 36" - 5# PKG
E70S2500POP	3/32" x 36" - 1# PKG
E70S2503POP	3/32" x 36" - 3# PKG
E70S2505POP	3/32" x 36" - 5# PKG
E70S2600POP	1/8" x 36" - 1# PKG
E70S2603POP	1/8" x 36" - 3# PKG
E70S2605POP	1/8" x 36" - 5# PKG

ER70S-3 (GTAW) TIG

A general purpose welding wire for fabrication of mild steel. Contains silicon and manganese as deoxidizers. Conforms to AWS A5.18 ER70S-3



PN: E70S330
1/16" x 36" - 10# PKG

Chemical Composition		
C-0.06-0.15%	Mn-0.90-1.40%	Si-0.45-0.75%
S-0.035%	P-0.025%	

PART NO.	SIZE
E70S330	1/16" x 36" - 10# PKGS
E70S350	3/32" x 36" - 10# PKGS
E70S360	1/8" x 36" - 10# PKGS

ER70S-6 (GTAW) TIG

A general purpose welding wire for fabrication of mild steel. Contains more deoxidizers than ER70S-3. The additional deoxidizers also provide better wetting, giving a flatter bead shape and the capability of faster travel speeds. Conforms to AWS A5.18 ER70S-6



PN: E70S6F0
.035 x 36" - 10# PKG

Chemical Composition			
C-0.06-0.15%	Mn-1.40-1.85%	Si-0.80-1.15%	S-0.035%
P-0.025%			

*Single values shown are maximum percentages.

PART NO.	SIZE
E70S6F0	.035" x 36" - 10# PKG
E70S6H0	.045" x 36" - 10# PKG
E70S630	1/16" x 36" - 10# PKG
E70S650	3/32" x 36" - 10# PKG
E70S660	1/8" x 36" - 10# PKG
E70S670	5/32" x 36" - 10# PKG
E70S6303POP	1/16" x 36" - 3# PKG
E70S6503POP	3/32" x 36" - 3# PKG
E70S6603POP	1/8" x 36" - 3# PKG
E70S6E8LW	.030" - 33# MS LEVEL WOUND
E70S6F8LW	.035" - 33# MS LEVEL WOUND
E70S6H8LW	.045" - 33# MS LEVEL WOUND

ER80S-D2 (GMAW) MIG

LOW ALLOY CR-MO WIRES FOR GMAW (MIG). Contains a high level of deoxidizers (Mn and Si), also Molybdenum for increased strength. Suitable for single and multi-pass welding of a variety of carbon and low alloy steels.

Procedure:

- DC+ reverse polarity
- Shielding gas - Argon
- Tungsten - 2% Thoriated

Specifications: AWS 5.28, ER80S-D2



PN: 80SD2H8
.045 - 33# SPOOL

Chemical Composition			
C-0.07-0.12%	Mn-1.60-2.10%	Si-0.50-0.80%	S-0.025%
P-0.025%	Ni-0.15%	Mo-0.40-0.60%	

PART NO.	SIZE
80SD2F8	.035" - 30# SPOOL
80SD2H8	.045" - 33# SPOOL