

BÖHLER Q S-6

Solid wire, unalloyed



Classifications	
EN ISO 14341-A	AWS A5.18 / SFA-5.18
G 42 3 M21 3Si1	ER70S-6M
G 38 2 C1 3Si1	ER70S-6C

Characteristics and typical fields of application

GMAW solid wire for welding unalloyed and low alloy steels. Low spatter in short and spray arc transfer modes with CO₂ or mixed gas. The wire is used in boiler, pipeline and structural constructions, shipbuilding and vehicle manufacturing.

Base materials

Steels with yield strength ≤ 60 ksi
 ASTM A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C; A 350 Gr. LF1; A 414 Gr. A, B, C, D, E, F, G; A 501 Gr. B; A 513 Gr. 1018; A 516 Gr. 55, 60, 65, 70; A 573 Gr. 58, 65, 70; A 588 Gr. A, B; A 633 Gr. C; A 662 Gr. B; A 711 Gr. 1013; A 841 Gr. A; API 5 L Gr. B, X42, X52, X56, X60

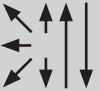


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Typical analysis of solid wire (wt.-%)			
	C	Si	Mn
wt.-%	0.08	0.9	1.45

Mechanical properties of all-weld metal						
Condition	Yield strength	Tensile strength	Elongation A (L ₀ =4d ₀)	Impact values CVN [ft.lb]		
	ksi	ksi	%	+68 °F	-4 °F	-22 °F
u	64 (≥ 61)	77 (73 – 97)	30 (≥ 20)	118		(≥ 34)
u ²	61 (≥ 55)	74 (68 – 87)	26 (≥ 20)	89	(≥ 34)	

u untreated, as-welded – shielding gas Ar + 15 – 25 % CO₂
u² untreated, as-welded – shielding gas 100 % CO₂

Operating data			
	Polarity: DC (+)	Shielding gases: Argon + 15 – 25 % CO ₂ 100 % CO ₂	ø (inch) 0.035 0.045 0.052

Approvals
ABS, CWB

Article number	Size [inch]	Weight spool / drum	Weight pallet [lbs]	Packaging
43587	0.035	33 lb spool	2079	Plastic Spool / D300
43588	0.035	44 lb spool	1980	Plastic Spool / D300
43589	0.035	550 lb drum	2200	ECOdrum 250
43590	0.035	880 lb drum	1760	ECOdrum 400
43591	0.045	33 lb spool	2079	Plastic Spool / D300
43592	0.045	44 lb spool	1980	Plastic Spool / D300
43593	0.045	550 lb drum	2200	ECOdrum 250
43595	0.045	880 lb drum	1760	ECOdrum 400
43596	0.052	44 lb spool	1980	Plastic Spool / D300
43597	0.052	550 lb drum	2200	ECOdrum 250
43598	0.052	880 lb drum	1760	ECOdrum 400

Country of Origin: USA