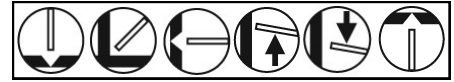


QCL-6



AWS ER70S-6

WELDING POSITIONS:



FEATURES:

- Smooth, stable arc in high to low wire feed speeds
- Low spatter levels in all processes
- Bead ties in smoothly to the weld joint
- Dependable feedability in all processes
- No copper flaking

BENEFITS:

- Increased productivity, consistent feeding
- Repeatable weld parameters
- Increased productivity, reduced clean-up time
- Smooth weld beads, with uniform tie in
- Increased flexibility with only one wire to inventory

APPLICATIONS:

- Frame fabrication
- Automotive structures
- Farm implements
- Construction equipment
- Pressure vessels
- Pipe fabrication
- General fabrication
- Railcar construction and repair

SHIELDING GAS: 100% Carbon Dioxide (CO₂), 75-92% Argon (Ar)/Balance Carbon Dioxide (CO₂) 25-50 cfh (12-24 l/min)

TYPE OF CURRENT: Direct Current Electrode Positive (DCEP)

STANDARD DIAMETERS: 0.035" (0.9 mm), 0.045" (1.2 mm)

RE-DRYING: Not recommended

STORAGE: Product should be stored in a dry, enclosed environment, and in its original intact packaging.

TYPICAL WELD METAL PROPERTIES* (Wire Chemistry):

Weld Metal Analysis	Wire Melt Button	AWS Spec
Carbon (C)	0.088	0.06-0.15
Manganese (Mn)	1.60	1.40-1.85
Silicon (Si)	0.88	0.80-1.15
Phosphorus (P)	0.013	0.025 max
Sulphur (S)	0.011	0.025 max
Copper (Cu)	0.04	0.50†

† Copper content of wire and copper coating shall not exceed .5% max.

TYPICAL MECHANICAL PROPERTIES* (As Welded):

Mechanical Tests	100% CO ₂	AWS Spec
Tensile Strength	79,000 psi (546 MPa)	70,000 psi (483 MPa) Minimum
Yield Strength	63,000 psi (436 MPa)	58,000 psi (400 MPa) Minimum
Elongation % in 2" (50 mm)	28%	22%

TYPICAL CHARPY V-NOTCH IMPACT VALUES* (As Welded):

CVN Temperatures	100% CO ₂	AWS Spec
Avg. at -20°F (-29°C)	77 ft•lbs (104 Joules)	20 ft•lbs (27 Joules) Minimum

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Hobart Brothers LLC expressly disclaims any liability incurred from any reliance thereon. Typical data are those obtained when welded and tested in accordance with the AWS A5.18 specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique not controlled by Hobart Brothers LLC.

QCL-6

Diameter Inches	(mm)	Transfer Mode	Amps	Volts	Wire-Feed Speed		Deposition Rate		Contact Tip to Work Distance	
					in/min	(m/min)	lbs/hr	(kg/hr)	Inches	(mm)
0.035	(0.9)	Short-Circuit	70	17.0	95	(2.4)	1.3	(0.6)	1/4	(6)
0.035	(0.9)	Short-Circuit	85	18.5	130	(3.3)	1.7	(0.8)	1/4	(6)
0.035	(0.9)	Short-Circuit	100	18.5	150	(3.8)	2.0	(0.9)	1/4	(6)
0.035	(0.9)	Short-Circuit	115	19.5	190	(4.8)	2.5	(1.1)	1/4	(6)
0.035	(0.9)	Short-Circuit	145	20.5	225	(5.7)	3.3	(1.5)	3/8	(10)
0.035	(0.9)	Short-Circuit	155	20.5	265	(6.7)	3.5	(1.6)	3/8	(10)
0.035	(0.9)	Spray	165	23.5	330	(8.4)	5.3	(2.4)	5/8	(16)
0.035	(0.9)	Spray	185	24.5	370	(9.4)	5.9	(2.7)	5/8	(16)
0.035	(0.9)	Spray	205	24.5	410	(10.4)	6.5	(2.9)	3/4	(19)
0.035	(0.9)	Spray	235	25.5	465	(11.8)	7.3	(3.3)	3/4	(19)
0.045	(1.2)	Spray	175	23.5	175	(4.4)	4.7	(2.1)	5/8	(16)
0.045	(1.2)	Spray	195	24.5	200	(5.1)	5.3	(2.4)	5/8	(16)
0.045	(1.2)	Spray	215	25.5	230	(5.8)	4.6	(2.1)	3/4	(19)
0.045	(1.2)	Spray	260	27.0	310	(7.9)	8.1	(3.7)	3/4	(19)
0.045	(1.2)	Spray	325	27.0	425	(10.8)	11.1	(5.0)	3/4	(19)
0.045	(1.2)	Spray	350	28.0	475	(12.1)	12.5	(5.6)	3/4	(19)
0.052	(1.4)	Spray	290	27.0	280	(7.1)	9.8	(4.4)	3/4	(19)
0.052	(1.4)	Spray	325	27.0	330	(8.4)	11.6	(5.2)	3/4	(19)
0.052	(1.4)	Spray	390	29.0	420	(10.7)	14.8	(6.7)	3/4	(19)

Note: Short circuit transfer shielding gas is 100% CO₂ or 75% Ar/25% CO₂ at 20-35 cfm (9-17 l/min)

Note: Spray transfer shielding gas is 90% Ar/10% CO₂ at 35-50 cfm (17-24 l/min)

- **Maintaining a proper welding procedure - including pre-heat and interpass temperatures - may be critical depending on the type and thickness of steel being welded.**
- **For out of position welding, short circuit or pulsed spray transfer modes must be used.**

COMMONLY ORDERED PART NUMBERS.

Diameter In.	(mm)	45-lb. (20.5kg) Spool	60-lb. (27kg) Spool	600-lb. (275kg) Robopak	950-lb. (430kg) Recyclable Robopak
0.035	(0.9)	S303808-085	—	S303808-011	—
0.045	(1.2)	S303812-085	S303812-028	S303812-011	S303812-070

Looking for a package or diameter NOT listed above? Please contact Hobart Brothers for a complete listing of product diameters and package sizes. Customer Service: (800) 424-1543, (937) 332-5188 for International Customer Service.

CONFORMANCES AND APPROVALS:

- **AWS A5.18**, ER70S-6
- **ASME SFA 5.18**, A-1
- **CWB W48-14 B-G 49A 3 C1 S6 (B-G 49A 3 C G6)**

TECHNICAL QUESTIONS? For technical support of Hobart Filler Metals products, contact the Applications Engineering department by phone toll-free at 1-800-532-2618 or by e-mail at Applications.Engineering@hobartbrothers.com

CAUTION:

Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standard Z49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36th St., Miami, FL 33166 (can also be downloaded online at www.aws.org); OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210

Safety Data Sheets on any Hobart Brothers LLC product may be obtained from Hobart Customer Service or at www.hobartbrothers.com.

Because Hobart Brothers LLC is constantly improving products, Hobart reserves the right to change design and/or specifications without notice.

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Revision Date: 180301 (Replaces 160208)

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