

## Pipeweld 70S-6 Plus

Pipeweld 70S-6 Plus is a copper free solid wire of very high purity for downhill circumferential GMAW welding on pipe qualities API 5L, Grade X52 to Grade X70. The electrode permits welding with high current (spray-arc) and also with short circuiting transfer in all positions.

### Tekniska data

|                  |                                                                                                                           |
|------------------|---------------------------------------------------------------------------------------------------------------------------|
| Klassificeringar | EN ISO 14341-A : G 42 2 C1 4Si1<br>EN ISO 14341-A : G 46 3 M21 4Si1<br>EN ISO 14341-A : G 4Si1<br>SFA/AWS A5.18 : ER70S-6 |
|------------------|---------------------------------------------------------------------------------------------------------------------------|

|              |                                                                            |
|--------------|----------------------------------------------------------------------------|
| Legeringstyp | Carbon-manganese steel (Mn/Si-alloyed)                                     |
| Skyddsgas    | M20, M21 (and other mixture of Ar and CO <sub>2</sub> ), C1 (EN ISO 14175) |

### Typiska mekaniska värden

| Villkor                               | Sträckgräns | Brottgräns | Förlängning |
|---------------------------------------|-------------|------------|-------------|
| <b>EN 80Ar/20CO<sub>2</sub> (M21)</b> |             |            |             |
| Helsvetsgods                          | 545 MPa     | 600 MPa    | 26 %        |
| <b>EN CO<sub>2</sub> (C1)</b>         |             |            |             |
| Helsvetsgods                          | 495 MPa     | 575 MPa    | 25 %        |
| <b>AWS CO<sub>2</sub> (C1)</b>        |             |            |             |
| Helsvetsgods                          | 470 MPa     | 575 MPa    | 29 %        |

### Slagseghetsdata Charpy V

| Villkor                               | Provningstemperatur | Slagseghet |
|---------------------------------------|---------------------|------------|
| <b>EN 80Ar/20CO<sub>2</sub> (M21)</b> |                     |            |
| Helsvetsgods                          | -20 °C              | 100 J      |
| Helsvetsgods                          | -30 °C              | 80 J       |
| Helsvetsgods                          | 20 °C               | 140 J      |
| <b>EN CO<sub>2</sub> (C1)</b>         |                     |            |
| Helsvetsgods                          | 20 °C               | 120 J      |
| Helsvetsgods                          | -20 °C              | 80 J       |
| <b>AWS CO<sub>2</sub> (C1)</b>        |                     |            |
| Helsvetsgods                          | -29 °C              | 80 J       |
| Helsvetsgods                          | -20 °C              | 100 J      |

### Svetsgodsanalys %

| C                                  | Mn   | Si   | S     | P     | Cu   |
|------------------------------------|------|------|-------|-------|------|
| <b>80Ar/20CO<sub>2</sub> (M21)</b> |      |      |       |       |      |
| 0.07                               | 1.25 | 0.82 | 0.009 | 0.009 | 0.02 |
| <b>CO<sub>2</sub> (C1)</b>         |      |      |       |       |      |
| 0.06                               | 1.05 | 0.72 | 0.009 | 0.009 | 0.02 |

### Trådens sammansättning %

| C     | Mn  | Si  |
|-------|-----|-----|
| 0.090 | 1.7 | 1.0 |