

Spoolarc EASY GRIND

Spoolarc Easy Grind is a fully deoxidized wire designed to weld over moderate levels of rust and paint as are commonly encountered in auto body repair work. Easy Grind produces welds that easily exceed the tensile requirements of ER70S class wires. The welded metal is "softer" than most commercial wires. This makes postwork grinding and cleaning easier and faster. Easy Grind is produced in small diameters and are appropriate for the low current welding machines commonly used in the body shops.

Specifications

Classifications	No AWS Classification
Industry	Industrial and General Fabrication Repair and Maintenance

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
75% Ar - 25% CO₂			
As Welded	497 MPa (72 ksi)	552 MPa (80 ksi)	24 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	-29 °C (-20 °F)	54 J (40 ft-lb)

Deposition Data

Diameter	Current	Deposition Efficiency (%)	Deposition Rate
0.8 mm (.030 in.)	100 A	93 %	1.13 kg/h (2.5 lbs/h)
0.8 mm (.030 in.)	100 A	96 %	1.18 kg/h (2.6 lbs/h)
0.8 mm (.030 in.)	100 A	98 %	1.18 kg/h (2.6 lbs/h)
0.8 mm (.030 in.)	150 A	93 %	1.77 kg/h (3.9 lbs/h)
0.8 mm (.030 in.)	150 A	96 %	1.81 kg/h (4.0 lbs/h)
0.8 mm (.030 in.)	150 A	98 %	1.86 kg/h (4.1 lbs/h)
0.8 mm (.030 in.)	200 A	93 %	2.95 kg/h (6.5 lbs/h)
0.8 mm (.030 in.)	200 A	96 %	3.04 kg/h (6.7 lbs/h)
0.8 mm (.030 in.)	200 A	98 %	6.7 kg/h (6.8 lbs/h)
0.8 mm (.030 in.)	75 A	93 %	0.82 kg/h (1.8 lbs/h)
0.8 mm (.030 in.)	75 A	96 %	0.86 kg/h (1.9 lbs/h)
0.8 mm (.030 in.)	75 A	98 %	0.91 kg/h (2.0 lbs/h)

Recommended Welding Parameters

Current	Wire Diameter	Voltage	Wire Feed Speed
100-125 A	0.6 mm (.023 in.)	23-25 V	1016-1575 cm/min (400-620 in./min)
45-90 A	0.6 mm (.023 in.)	14-16 V	381-965 cm/min (150-380 in./min)
160-200 A	0.8 mm (.030 in.)	24-26 V	1270-1651 cm/min (500-650 in./min)
60-140 A	0.8 mm (.030 in.)	14-16 V	381-889 cm/min (150-350 in./min)