

Spoolarc 86 Tigrod

Spoolarc 86 is a copper-coated TIG rod containing high levels of manganese and silicon. Spoolarc 86 is suitable for many carbon steel welding applications using the MIG/Gas Metal Arc Welding (GMAW) process. The high levels of deoxidizers in Spoolarc 86 provide excellent tolerance of rust and mill scale. The high levels of manganese and silicon also provide excellent wetting action and a highly fluid weld puddle. Shielding gas choices for Spoolarc 86 in the GMAW mode are 100% carbon dioxide, argon/carbon dioxide mixtures, argon/oxygen mixtures, and other argon based mixed gas blends. Spoolarc 86 excels in HVAC duct work, heavy equipment fabrication, structural, and other general steel fabrication.

Specifications	
Classifications	AWS A5.18 : ER70S-6 AWS A5.17 : EH11K
Approvals	CSA : CAN/CSA-ISO14341, B-G 49A 3C G6 (ER49S-6) CWB : CSA W48 MIL-E-23765/1 : 70S-6
Industry	Automotive HVAC Industrial and General Fabrication Mobile Equipment Ship/Barge Building

Approvals are based on factory location. Please contact ESAB for more information.

Typical Wire Composition %								
C	Mn	Si	S	P	Ni	Cr	Mo	Cu
0.08	1.51	0.01	0.01	0.008	0.01	0.02	0.01	0.11