

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 EN ISO 14341-A : G 46 3 M21 4Si1 EN ISO 14341-A : G 4Si1 SFA/AWS A5.18 : ER70S-6
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Legeringstyp	Carbon-manganese steel (Mn/Si-alloyed)
Skyddsgas	M20, M21 (and other mixture of Ar and CO ₂), C1 (EN ISO 14175)

Typiska mekaniska värden

Villkor	Sträckgräns	Brottgräns	Förlängning
EN 80Ar/20CO₂ (M21)			
Helsvetsgods	545 MPa	600 MPa	26 %
EN CO₂ (C1)			
Helsvetsgods	495 MPa	575 MPa	25 %
AWS CO₂ (C1)			
Helsvetsgods	470 MPa	575 MPa	29 %

Slagseghetsdata Charpy V

Villkor	Provnings temperatur	Slagseghet
EN 80Ar/20CO₂ (M21)		
Helsvetsgods	-20 °C	100 J
Helsvetsgods	-30 °C	80 J
Helsvetsgods	20 °C	140 J
EN CO₂ (C1)		
Helsvetsgods	20 °C	120 J
Helsvetsgods	-20 °C	80 J
AWS CO₂ (C1)		
Helsvetsgods	-29 °C	80 J
Helsvetsgods	-20 °C	100 J

Svetsgodsanalys %

C	Mn	Si	S	P	Cu
80Ar/20CO₂ (M21)					
0.07	1.25	0.82	0.009	0.009	0.02
CO₂ (C1)					
0.06	1.05	0.72	0.009	0.009	0.02

Trådens sammansättning %

C	Mn	Si
0.090	1.7	1.0