

# Executive 70S-6 CF

*Executive*  
FILLER METALS

## **A copper free alternative for ER70S-6.**

**Executive 70S-6 CF** is the latest generation of carbon steel wire designed to reduce your overall welding costs. Whether you are operating in manual or robotic modes, this copper free wire will allow you to achieve new levels of performance by reducing overall welding costs.

Exocor's proprietary coating on the wire virtually eliminates copper contamination of your feeding equipment and significantly prolongs the life of your contact tips, nozzles, gas diffusers, liners, and feed rolls. Low fume emission creates a healthier work environment for welders and shop personnel alike.

Every heat of wire has been impact tested in accordance with current ASME requirements and is shipped complete with certified actual mechanical properties.

**Executive 70S-6 CF** increases productivity, operates effectively with CO<sub>2</sub> or Argon mixed gas, improves weld quality, promotes a cleaner work environment and reduces overall welding costs in the process!

## **Executive 70S-6 CF Advantages**

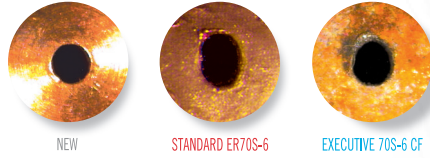
- Extends life of all consumable MIG parts
- Superior feedability with no copper flaking
- Low fume emissions
- Smoother bead appearance
- Higher productivity

# Executive 70S-6 CF

## LESS WEAR

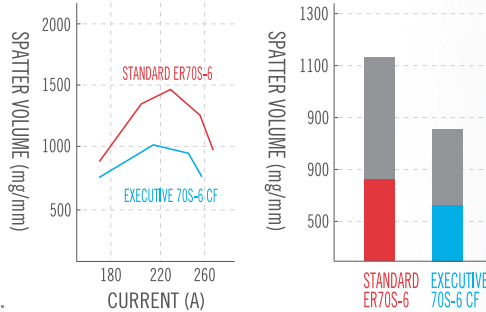
Contact tip wear is significantly reduced with copper free Executive 70S-6 CF wire due to spatter reduction and no copper flake buildup. The tips below were checked before and after welding with the wires.

The Executive 70S-6 CF contact tip shows little signs of wear.



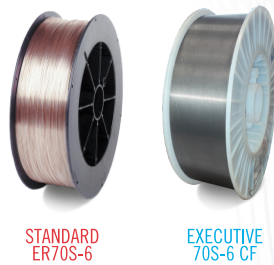
## SPATTER

The spatter generated by Executive 70S-6 CF is minimal and easy to clean up. See the comparison between Executive 70S-6 CF and Standard ER70S-6.



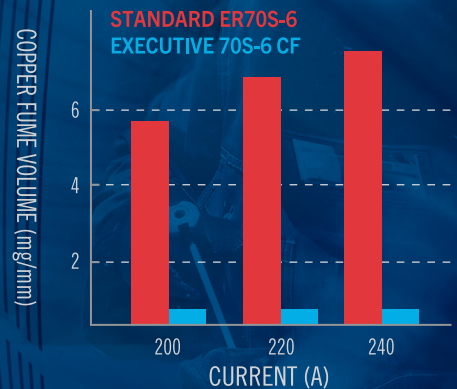
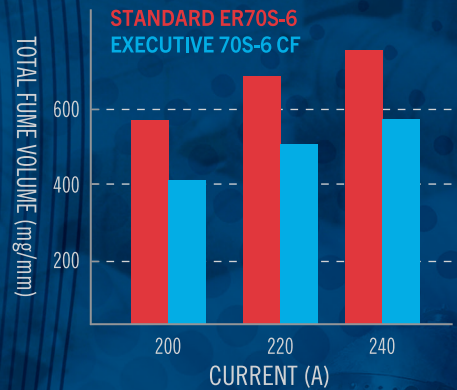
## ANTI-RUST

One spool of a copper coated STANDARD ER70S-6 and Executive 70S-6 CF wire were left in an indoor atmosphere for two weeks to test the anti-rust property. The room temperature was 30°C (86°F) and the relative moisture was 80%. The copper free surface of the Executive 70S-6 CF is entirely rust free.



## FUMES

Reducing welding fumes was a clear objective when formulating Executive 70S-6 CF. Low copper emission creates a healthier work environment for welders and shop personnel alike.



## Executive 70S-6 CF

### TYPICAL CHEMICAL COMPOSITION

### TYPICAL MECHANICAL PROPERTIES AS WELDED

CLASSIFICATION	TYPICAL CHEMICAL COMPOSITION										TYPICAL MECHANICAL PROPERTIES AS WELDED		
	C	Cr	Ni	Mo	Mn	Si	P	V	S	Cu	Yield Strength (mPa)	Tensile Strength (mPa)	Elongation %
ER70S-6	0.06	0.05	0.03	0.01	1.5	0.85	0.01	0.01	0.01	0.07	530	570	27

Executive 70S-6 CF is available in .035", .045" on 44-lb spools, and 550-lb drums. \*A variety of sizes and packaging options are available upon request.

Wire chemistry conforms to AWS/SFA 5.18, Class ER70S-6 and is certified for GMAW by the CWB to classification B-G 49A 3 C1 S6 of CSA Standard W48.