

# Executive 70S-6 CFP

*Executive*  
FILLER METALS

**A copper free alternative for ER70S-6, impact tested to 20 ft-lb at -50°C (-58°F)**

Executive 70S-6 CFP 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/lot of wire has been impact tested in accordance with current ASME requirements to **20 ft-lb at -50°C (-58°F)** and is shipped complete with certified actual mechanical properties.

Executive 70S-6 CFP 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 CFP Advantages

- Tested to 20 ft-lb at -50°C (-58°F)
- Extends life of all consumable MIG parts
- Superior feedability with no copper flaking
- Low fume emissions
- Smoother bead appearance
- Higher productivity

TESTED  
27 J / -50°C  
20 ft-lb / -58°F



# Executive 70S-6 CFP

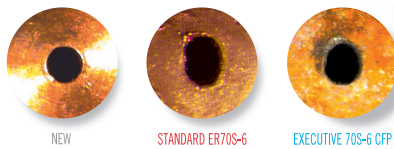
## LOW TEMP

Executive 70S-6 CFP comes certified with actual mechanical impacts of 20 ft-lb at -50°C (-58°F).



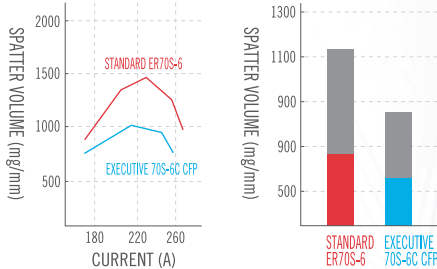
## LESS WEAR

Contact tip wear is significantly reduced with copper free Executive 70S-6 CFP 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 CFP contact tip shows little signs of wear.



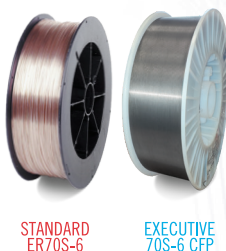
## SPATTER

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



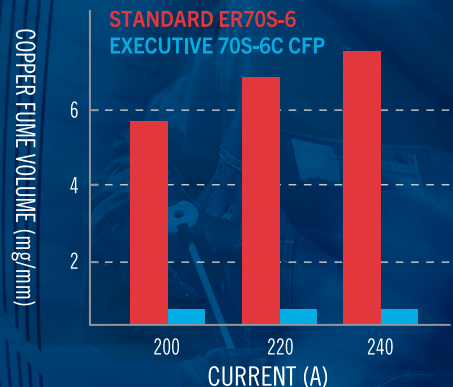
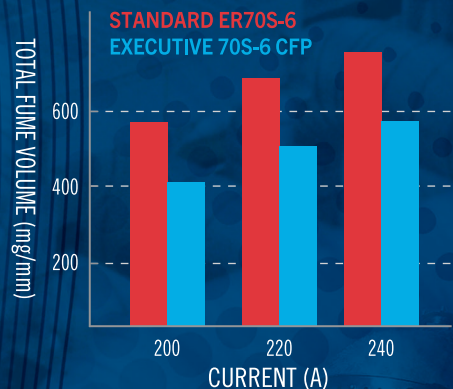
## ANTI-RUST

One spool of a copper coated STANDARD ER70S-6 and Executive 70S-6 CFP 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 CFP is entirely rust free.



## FUMES

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



## Executive 70S-6 CFP

### TYPICAL CHEMICAL COMPOSITION

### TYPICAL MECHANICAL PROPERTIES AS WELDED

CLASSIFICATION	C	Cr	Ni	Mo	Mn	Si	P	V	S	Cu	Yield Strength (mPa)	Tensile Strength (mPa)	Elongation %	CVN*	
														-29°C (-20°F)	-50°C (-58°F)
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	90 J (66ft-lb)	80 J (59ft-lb)

\* Shielding Gas: 80% Ar / 20% CO<sub>2</sub>

Executive 70S-6 CFP 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.