

# EXECUTIVE 70C-6 MC

## CARBON STEEL

### METAL CORED WIRE TECHNICAL DATA SHEET

#### DESCRIPTION

Executive 70C-6 MC is a low fume premium quality metal cored wire intended for single or multi-pass welding in a variety of steel weldments and fabrications. This wire produces minimal silicon islands that are easily removed.

Certified test reports that include certification to AWS D1.8 for critical seismic applications with actual chemistry and mechanicals for 90% Ar / 10% CO<sub>2</sub> shielding gas is provided with each lot, which is unique in industry.

Compared to solid or flux cored wires like Executive 71CM, Executive 70C-6 MC has higher deposition rates and faster travel speeds.

#### APPLICATIONS & FEATURES

Easy to use, with very smooth arc characteristics allowing for great operator appeal. Higher deposition rates compared to solid wire or flux cored in the flat position as well as superior gap bridging capabilities.

Typical applications include transportation and agricultural equipment manufacturing, structural fabrication, rail cars, storage vessels and shipping components. Wire is optimized for pulse welding applications.

#### TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Mn	Si	P	S	Cu	Ni	Cr	Mo	V
0.04	1.60	0.62	0.008	0.002	0.07	0.28	0.02	0.01	0.01

<b>Tensile Strength:</b>	82,800 PSI min	<b>Diffusible Hydrogen:</b>	2.4 ml / 100g	<b>Charpy Impact:</b>	50 ft-lb at -40°F (-40° C)
<b>Yield Strength:</b>	71,600 PSI min	<b>Elongation:</b>	32%		

#### TYPICAL WELDING PARAMETERS\*

Diameter	Voltage	Amperage	WFS (in/min)	Shielding Gas
.035"	24	150	320	*Typical welding parameters are for 90% Ar / 10% CO <sub>2</sub>  If using a gas mixture with higher levels of CO <sub>2</sub> the voltage should be gradually increased by 1-3 volts
	28	200	480	
.045"	25	230	280	
	26	240	300	
	26.5	260	330	
	27	280	380	
	29	300	410	
.052"	27	230	260	
	30	270	295	
	31	300	365	
.062"	28	300	230	
	29	330	270	
	31	360	300	

#### STANDARD PACKAGING

<b>Spools</b>	44-lb plastic spools	2,640-lb pallet	26" diameter
<b>Drums</b>	660-lb per drum	1,320-lb pallet	

#### CLASSIFICATION

AWS A5.18 (2005)/ASME SFA A5.18 Class E70C-6M H4  
 AWS A5.36 (2016)/ASME SFA A5.36 Class E70T15-M20/M21A4-CSI-H4  
 CWB E491T15-M20A4-CSI-H4 (E491C-6MJ-H4),  
 E491T15-M21A4-CSI-H4 (E491C-6MJ-H4)

