

DESCRIPTION

Executive 70S-2 is a copper free wire is the optimal choice when welding through rust, dirt, and mill scale. While primarily used for single pass welding on deoxidized and partially deoxidized steels Executive 70S-2 is suitable for some multi-pass applications as well.

This filler metal is also well suited for use in single side, melt through welding without a protective root shielding gas on the backside of the joint.

Executive 70S-2 TIG wire has a copper coating and is used to produce high quality, high toughness welds with the GTAW process.

APPLICATIONS & FEATURES

Typical applications include automotive, structural steel, carbon steel pipe, and plate.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Si	Mn	P	S	Cr	Mo	V	Ti	Cu	Zr	Al	Ni
0.04	0.50	1.10	0.01	0.01	0.15	0.15	0.03	0.1	0.50	0.05	0.1	0.15
Tensile Strength:		82,000 PSI min		Yield Strength:		68,000 PSI min		Elongation:		28%		

TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Speed (in/min)	Shielding Gas
GMAW - Short	.035"	18	80	100	Ar / CO ₂ Blends Ar / O ₂ Blends 100% CO ₂
		19	120	150	
		22	175	250	
	.045"	19	145	125	
		20	165	150	
		21	200	200	
- Spray	.035"	23	195	375	Ar / CO ₂ Blends Ar / O ₂ Blends
		29	230	500	
		30	275	600	
	.045"	27	285	350	
		30	335	475	
		30	340	500	
		30	340	500	
GTAW	.093"	Direct Current; Electrode -			100% Ar
	.125"				

STANDARD PACKAGING

GMAW (MIG)	33-lb wire baskets	1,980-lb pallet
GTAW (TIG)	10-lb plastic tube	40-lb carton

CLASSIFICATION

AWS/SFA 5.18, Class **ER70S-2**

