

DESCRIPTION

Executive 70S-3 CF (Copper Free) is a high quality, general purpose welding wire widely used for GMAW fabrication of mild steel material.

Executive 70S-3 CF is designed to be the ultimate in trouble free welding performance with smooth feedability and excellent arc stability. The weld puddle of this wire is more fluid than ER70S-2, producing better wetting characteristics and a flatter bead.

Executive Copper Free wire is specially designed to reduce wear on consumables and produce great clean welds that require minimal clean-up. This is all to help improve arc on time to keep you welding.

APPLICATIONS & FEATURES

Typical applications include automotive, structural steel, carbon steel pipe, and plate. Suitable shielding gases for GMAW applications using ER70S-3 wires include Argon/CO₂, or Argon/O₂ with higher Argon content as well as 100% CO₂.

While designed for use on clean plate Executive 70S-3 CF has moderate levels of silicon and manganese deoxidizers will allow you to weld through light millscale.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Sn	Al	N
0.07	0.6	1.21	0.01	0.008	0.50	0.15	0.02	0.15	0.004	0.004	0.002	.005
Tensile Strength:		82,600 PSI min		Yield Strength:		69,500 PSI min		Elongation:		33%		
Charpy V-Notch:		145 ft/lb at 32°F / 0°C										
		129 ft/lb at -4°F / -20°C										

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	
- Spray	.035"	21	200	200	Ar / CO ₂ Blends Ar / O ₂ Blends
		23	195	375	
		29	230	500	
	.045"	30	275	600	
		27	285	350	
		30	335	475	
		30	340	500	

STANDARD PACKAGING

GMAW (MIG) 33-lb spools 1,980-lb pallet

CLASSIFICATION

AWS/SFA 5.18, Class ER70S-3 and CWB B-G 49A 2 C1 S3

