



Standards

CSA W48, Class ER49S-6, CAN/CSA ISO 14341
 Class B-G 49A 3 C1 S6 (B-G 49A 3 C G6) AWS A5.18/ASME SFA 5.18,
 Class ER70S-6

Description & Applications

It is a lightly copper-coated carbon steel solid wire electrode for Gas Metal Arc Welding (GMAW). It may be used in single or multi-pass welding in all GMAW transfer modes: short circuit, globular, spray or pulsed spray transfer mode. Commonly used to weld low and medium carbon steels, as well as some low alloy steels.

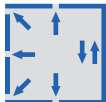
- Typical applications include heavy industrial fabrication, automotive manufacturing (Bodies), general fabrication and repair of dirty or mill-scaled materials.

The BLUESHIELD™ Advantage

- Offers a smooth stable arc transfer and excellent bead profile.
- Low hydrogen weld deposit.
- High deposit rate and efficiency.

Typical Welding Parameters

- All position weld capabilities when using either short circuit or pulsed spray transfer.
- Direct current electrode positive (DCEP) is recommended.



DIAMETER		APPLICABLE RANGE	
mm	in	Amps	Volts
0.6	0.023	60-140	16-22
0.8	0.030	80-160	18-24
0.9	0.035	100-220	18-26
1.2	0.045	100-240	18-28

Recommended Shielding Gases

CWB certification 100% Co2 according to CSA W48.

It is recommended to use BLUESHIELD™ 6, BLUESHIELD™ 7, BLUESHIELD™ 8, ARCAL™ M23 (BLUESHIELD™ 23) gas mixtures for MIG welding.

Typical Wire Chemistry

WEIGHT	C	Mn	Si	P	S	Ni	Cr	Mo	V	Cu
%	0.09	1.65	0.95	0.010	0.006	0.008	0.018	<0.15	<0.030	0.35

Typical Mechanical Properties*

	AS WELDED CO ₂
TENSILE STRENGTH MPa (ksi)	536 (77.7)
YIELD STRENGTH MPa (ksi)	428 (62.1)
ELONGATION (%)	28
IMPACT (Charpy V-notch) @ -30°C (-20°F)	94 J (69 ft-lb)

* Actual welding positions and procedures can impact results.



Packaging

mm	DIAMETER		kg	PACKAGING		ITEM NUMBER
	in			lb		
0.6	0.023		1	2.2	Spool	A0418514
0.8	0.030					A0418518
0.9	0.035					A0418520
1.2	0.045					A0418530
0.6	0.023		5	11	Spool	A0418515
0.8	0.030					A0418516
0.9	0.035					A0418523
1.2	0.045					A0418532
0.8	0.030		20	44	Spool	A0418456