



IRON AND STEEL
PRODUCTS

Copper Coated Solid Rod for GTAW

- **Product description:**

Welding rods produced by Zanjan wire Ind. is a copper coated Mn-Si —alloyed ER70S-6,W35Si1 solid rod for the GTAW of non-alloyed steel with a tensile strength up to 540 MPa.

Characteristic features include Smooth bead appearance.

- **Production standard:**

BS EN ISO 636	Product Code: WSSi1
AWS A5.18	Product Code: ER70S-6

- **Technical specifications:**

1. Chemical composition of welding wire

C	Si	Mn	P	S
0.06-0.15	0.80-1.15	1.40-1.85	Max 0.025	Max 0.035

2. Mechanical properties of all-weld

Yield stress (MPa)	Tensile Strength (MPa)	Elongation (%)	Impact Test
Min 400	Min 480	Min 22	According to EN and AWS

3. Packaging:

5 kg packages in sizes of 1.60 - 2.00 - 2.40 - 3.20 mm







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