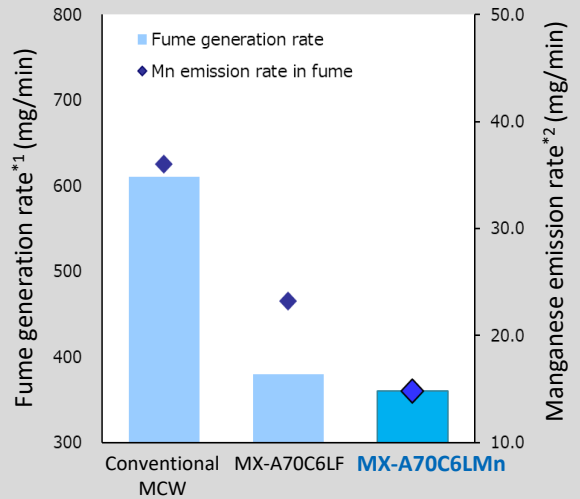




Features and typical fields of application

- MX-A70C6LMn is a 70ksi class mild steel metal cored wire for flat and horizontal welding with 75-95%Ar-bal. CO₂ mixed gas.
- While maintaining the features of MX-A70C6LF such as extremely low fume, low spatter, and excellent mechanical properties, the Manganese emission in its welding fume has been reduced.
- This contributes to reduce Manganese exposure of workers at welding sites and realizes a safer working environment.
- It provides higher deposition rates than solid wires.



*1) Fume generation rate testing according to ISO 15011-1

*2) Analysis of Mn content in fume according to JIS Z3920 (ICP-AES, similar to ASTM E350)

Bead appearance



MX-A70C6LMn, 0.045", Horizontal Fillet Welding with 90%Ar+10%CO₂ mix gas

Typical mechanical property of weld metal per AWS A5.18

Shielding Gas	0.2% PS (ksi)	TS (ksi)	El (%)	CVN at -20°F (ft-lbs)
75%Ar-25%CO ₂	62	76	30	64

Typical chemical composition of weld metal per AWS A5.18

Shielding Gas	C	Si	Mn	P	S	Diffusible Hydrogen Content* (mL/100g)
75%Ar-25%CO ₂	0.04	0.80	0.90	0.009	0.009	3.3

*: Gas chromatography method (AWS A4.3)



Recommended welding conditions and deposition rate

Wire Dia.	Wire Feed Speed (in/min)	Current (A)	Arc Voltage (V)	Deposition Rate (lbs/hr)	Wire Stick-Out	Shielding Gas flow rate (CFH)
0.045"	120	120	21-24	3.3	3/4"	40-50
	185	160	23-26	5.0		
	230	200	24-27	6.2		
	270	220	25-28	7.2		
	290	230	26-29	7.8		
	360	260	28-31	9.8		

Table shown are approximate values that will vary depending on welding conditions (WESO, Cable length etc.).

Available Products

Wire Dia.	0.045"	Package	33 lbs spool
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DISCLAIMER

- Information in this material, such as chemical compositions and mechanical properties, is typical or an example for explaining the features and performances of our products, and it does not mean guarantee unless otherwise it is specified.
- Information contained herein is subject to change without notice. Please kindly contact Kobelco for latest information.



WARNING: This product can expose you to chemicals including Nickel and Titanium Dioxide, which are known to the State of California to cause cancer, and Chromium, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to www.P65Warnings.ca.gov.

KOBELCO WELDING OF AMERICA INC.



4755 Alpine Drive, Suite 250, Stafford, Texas 77477
TEL: 281-240-5600 FAX: 281-240-5625
<http://www.kobelcowelding.com>