



## Features and Typical fields of application

- MX-A70C6SA is a 70ksi class mild steel metal cored wire for flat and horizontal welding with 75-95%Ar-bal.CO<sub>2</sub> mixed gas.
- Its low fume emission, minimized spatter generation formula creates a clean welding environment at any welding condition.
- This wire is specifically developed to produce high deposition rates suitable for heavy industrial applications over conventional solid wire.
- It produces a flat and smooth bead profile even when welding steel plates with mil scale, making it the superior choice for general fabrication, especially for the structural steel industry including AWS D1.8 seismic applications.

### Bead appearance



MX-A70C6SA, .045", Horizontal Fillet Welding with 75%Ar-25%CO<sub>2</sub> gas

## Mechanical properties of all-weld metal per AWS A5.18 and D1.8

Code	Shielding Gas	0.2% PS (ksi)	TS (ksi)	EI (%)	CVN (ft-lbs)
AWS A5.18	75%Ar-25%CO <sub>2</sub>	65	84	29	68 at -20°F
	90%Ar-10%CO <sub>2</sub>	68	86	24	59 at -20°F
AWS D1.8 Low H. Ipt: 29kJ/in	75%Ar-25%CO <sub>2</sub>	75	89	25	125 at +70°F
AWS D1.8 High H. Ipt: 65kJ/in		59	78	31	116 at +70°F

## Chemical composition of all-weld metal per AWS A5.18 (%)

Shielding Gas	C	Si	Mn	P	S
75%Ar-25%CO <sub>2</sub>	0.06	0.78	1.48	0.011	0.012
90%Ar-10%CO <sub>2</sub>	0.07	0.80	1.54	0.011	0.011



Diffusible Hydrogen Content per AWS A4.3	Approvals
1.8 mL/100g	AWS D1.8

### 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
0.045"	134	120	20-22	3.3	3/4"
	197	160	24-26	4.7	
	268	200	27-29	6.6	
	307	220	28-30	7.6	
	378	260	31-33	9.7	

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](http://www.P65Warnings.ca.gov).

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