

HUATONG

HTW-50

AWS ER70S-6

Typical applications

Butt and fillet welding of vehicles, building, ships, machinery and bridges in all positions.

Characteristics on Usage

- ▶ Suitable for high speed welding of steel sheets by short circuiting transfer in all positions
- ▶ Flow quantity of shielding gas should be 20l/min in general.
- ▶ Keep the distance between tip and base plate metal 6~15mm for 250 Amp. And under or within 15~25mm for more than 250 Amp. Of welding current.

Mild, high tensile steel

GB	AWS	BS EN ISO	shielding gas
ER50-6	ER70S-6	3Si1	C1/M21

Mechanical properties of the deposited metal

Yield Strength MPa	Tensile Strength MPa	Elongation (%)	Impact J/°C
450	550	30	97/-30

Chemical composition of the deposited metal (%)

C	Si	Mn	P	S	Mo	Ti
0.09	0.83	1.13	0.010	0.012	-	-

Application

Mild steel, 491MPa high tension steel, full position welding, high current

Item	Unit	D100	D200 Euro	D200 US	D250	D270	D300	K300	S300	250 Drum	350 Drum
Breadth/Height	mm	45	60	55	104	104	104	100	100	810	760
Inner diameter	mm	16	52.5					-	50.5	510	660
Drive hole	mm	-	12					-	-	-	-
Weight fitness	kg	≤1	≤5	≤5	≤15	≤20	≤20	≤20	≤20	≤250	≤410