

HUATONG

HTW-58

AWS ER70S-G

Typical applications

Butt and fillet welding of vehicles, electric products, ships, machinery and bridges.

Characteristics on Usage

- ▶ A solid wire for high current welding in all positions.
- ▶ Stable arc and low spatter.
- ▶ Suitable for high speed welding of thick plates.
- ▶ Good crack resistance of the deposited weld metal.

Mild,high tensile steel

GB	AWS	BS EN ISO	shielding gas
ER50-G	ER70S-G	z	C1/M21

Mechanical properties of the deposited metal

Yield Strength MPa	Tensile Strength Mpa	Elongation (%)	Impact J/°C
470	560	31	96/-30

Chemical composition of the deposited metal (%)

C	Si	Mn	P	S	Mo	Ti
0.09	0.60	1.21	0.012	0.010		defined amount

Application

Mild steel, 490MPa high tension steel, 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	