

PRODUCT DESCRIPTION:

NS Plus™-115 is a premium copper-coated mild steel solid filler metal containing a high combined total of manganese and silicon. The wire produces a smooth, uniform welding arc, which minimizes weld spatter and results in excellent bead appearance and high operator appeal. The excellent operating characteristics of NS Plus™-115 appeal to users seeking better performance in their ER70S-6 applications.

NS PLUS™ PREMIUM WELDING WIRE CHARACTERISTICS:

- NS Plus™ Premium Copper-Coated Welding Wire sets the standard in quality to support your GMAW operations.
- Cast of 35"(.88m) to 55" (1.3m) and Helix below 1" (25.4mm) improve feedability and provide accurate wire positioning
- Higher Silicon content reduces the molten metal surface tension, resulting in flatter bead profiles
- Manufactured according to ISO9001:2008 quality standards

Mild steel GMA welding wire for industrial and light duty applications

CLASSIFICATIONS & APPROVALS:

- AWS A5.18: ER70S-6 H4
- ASME SFA-5.18: ER70S-6
- MIL-E-23765/1: MIL-70S-6
- CWB W48-01: ER49S-6

WELDING POSITIONS:

All position welding is possible when using the correct shielding gas blends, welding process and parameters.

NS PLUS™-115	PRODUCT FEATURES
ARC STARTS	Excellent
ARC STABILITY	Excellent
FEEDABILITY	Excellent
SPATTER	Minimal
COPPER FLAKING	Minimal
DE-OXIDIZERS	High level
WELD APPEARANCE	Excellent
POST WELD CLEANING	Excellent

TYPICAL APPLICATION SHIELDING GAS BLENDS:

- 100% CO₂
- 75-95% Argon/Balance CO₂
- 95-98% Argon/Balance O₂
- Flow Rate: 35-50 CFH

WIRE DIAMETERS (in):

.035	.040	.045	.052	.062
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NS PLUS™-115 APPLICATIONS:

- Well suited for all metal transfer modes of GMAW
- Robotic, mechanized or semi-automatic welding
- Welding steel with mill scale, rust or oil
- Used for single and multi-pass weldments
- Applications requiring yield strengths greater than 50,000 psi

TYPICAL MECHANICAL PROPERTIES:

	TENSILE STRENGTH PSI	YIELD STRENGTH PSI	MINIMUM ELONGATION %	CVN IMPACT VALUES @ -20° F
NS PLUS™-115	82,200	65,200	29	60 ft-lbf
AWS MINIMUM	70,000	58,000	22	20 ft-lbf

Typical conducted with CO₂ shielding gas
Wire performance data available upon request





TYPICAL WIRE CHEMISTRY PERCENTAGES:

	C	Mn	Si	P	S	Cu	Ni	Cr	Mo	V
NS PLUS™-115 TYP.	0.08	1.49	0.90	0.011	0.010	0.14	0.05	0.04	0.008	0.006
AWS A5.18	0.06/0.15	1.40/1.85	0.80/1.15	0.025 (max.)	0.035 (max.)	0.50 (max.)	0.15 (max.)	0.15 (max.)	0.15 (max.)	0.03 (max.)

NS PLUS™ WELDING PARAMETERS AND PACKAGE OPTIONS 

APPROXIMATE WELDING PARAMETERS:

GRADE	DIA.	POLARITY	TRANSFER MODE	WIRE FEED SPEED in/min (m/min)		VOLTAGE		AMPERAGE	
				Min.	Max.	Min.	Max.	Min.	Max.
Copper-Coated	0.035	DCEP	Short Circuit	100 (2.5)	400 (10.1)	18	24	75	180
Copper-Coated	0.035	DCEP	Spray	375 (9.5)	625 (15.9)	24	30	180	280
Copper-Coated	0.045	DCEP	Globular	100 (2.5)	425 (10.8)	19	25	125	225
Copper-Coated	0.045	DCEP	Short Circuit	125 (3.2)	450 (11.4)	19	25	125	225
Copper-Coated	0.045	DCEP	Spray	350 (8.9)	500 (12.7)	27	31	250	350
Copper-Coated	0.052	DCEP	Globular	175 (4.4)	300 (7.6)	19	27	150	250
Copper-Coated	0.052	DCEP	Short Circuit	200 (5.1)	325 (8.3)	23	27	200	300
Copper-Coated	0.052	DCEP	Spray	300 (7.6)	500 (12.7)	30	32	300	425
Copper-Coated	0.062	DCEP	Globular	180 (4.6)	320 (8.1)	20	28	150	250
Copper-Coated	0.062	DCEP	Short Circuit	190 (4.8)	325 (8.3)	24	28	200	325
Copper-Coated	0.062	DCEP	Spray	200 (5.1)	375 (9.5)	28	32	325	420

PACKAGES
33-lb. Fiber Spool - Random Wound
33-lb. Wire Basket - Precision Layer Level Wound
45-lb. Fiber Spool - Random Wound
45-lb. Wire Basket - Precision Layer Level Wound
60-lb. Fiber Spool - Random Wound
250-lb. Smart Pak - 100% Recyclable
300-lb. Tru-Trac® 
500-lb. Drum Pack
500-lb. Smart Pak - 100% Recyclable
900-lb. Drum Pack
900-lb. Smart Pak - 100% Recyclable
425-lb. Trigger Trac® 
1,000-lb. Tru-Trac® 
1,000-lb. Wood Reel
<i>Note: See "Premium Packaging Options" for full description of packages. For additional packages, please contact NS Customer Service at 1-800-777-1618.</i>
 Exclusive to NS customers.

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For Material Safety Data Sheets (MSDS) and Certificates of Compliance, visit our website at www.nationalstandard.com

