



## Viking AWS ER70S-6

### DESCRIPTION

Viking is a premium copper coated import MIG welding wire that is well-suited for general GMAW welding applications. (Sold only in pallet quantities.)

### CHARACTERISTICS

Choose Viking for:

- Welding steel with mill scale, rust or oil
- Single to multi-pass welding applications

**PRODUCED IN:** China

### SPECIFICATIONS

Meets or exceeds:

- ER70S-6 (AWS A5.18, ASME SFA 5.18)
- ER49S-6 (CWB/CSA W48-14)

### APPLICATIONS

Well-suited for these applications:

- General GMAW applications
- Welding steel with mill scale, rust or oil
- Single to multi-pass welding applications
- MIG Metal Inert Gas
- MAG Metal Active Gas
- GMAW Gas Metal Arc Welding
- For DC+ CC/CV

### SHIELDING GAS BLENDS

Typical Application Shielding Gas Blends:

- 100% CO<sub>2</sub>
- 75-95% Argon/Balance CO<sub>2</sub>
- 95-98% Argon/Balance O<sub>2</sub>
- Flow Rate: 35-50 SCFH

### WELDING POSITIONS

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

### STORAGE

Welding wire should be stored in a dry, enclosed environment and in its originally-sealed package.

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# VIKING WELDING WIRES

## TYPICAL MECHANICAL PROPERTIES (as welded)

	TENSILE STRENGTH PSI	YIELD STRENGTH PSI	MINIMUM ELONGATION %	CVN IMPACT VALUES @ 20° F
S-6 Typical*	88,800	73,500	27	39 ft-lbf
<b>AWS MINIMUM</b>	<b>70,000</b>	<b>58,000</b>	<b>22</b>	<b>20 ft-lbf</b>

\*Typical conducted with CO<sub>2</sub> shielding gas.

## APPROXIMATE WELDING PARAMETERS

GRADE	DIA.	POLARITY	TRANSFER MODE	SHIELDING GAS	WIRE FEED SPEED in/min	VOLTAGE	AMPERAGE
S-6	0.035	DC+	Short Circuit	100% CO <sub>2</sub>	100-150-250	18-19-22	80-100-150
	0.035		Spray	90% Argon/ 10% CO <sub>2</sub>	375-500-600	27-30-30	195-210-250
	0.045		Short Circuit	100% CO <sub>2</sub>	125-150-200	19-20-21	145-145-175
	0.045		Spray	90% Argon/ 10% CO <sub>2</sub>	350-475-500	27-30-30	285-315-315

## TYPICAL WIRE CHEMISTRY PERCENTAGES (as required per AWS)

	C	Mn	Si	P	S	Cu	Ni	Cr	Mo	V
S-6 Typical	0.06	1.45	0.85	0.02	0.025	0.07	0.06	0.06	0.01	0.01
<b>AWS A5.18</b>	<b>0.06/0.15</b>	<b>1.40/1.85</b>	<b>0.80/1.15</b>	<b>0.025 (max.)</b>	<b>0.035 (max.)</b>	<b>0.50 (max.)</b>	<b>0.15 (max.)</b>	<b>0.15 (max.)</b>	<b>0.15 (max.)</b>	<b>0.03 (max.)</b>

## PACKAGING DIMENSIONS

DIAMETER	PART#	PKG	LBS	PKG DIMENSIONS (inches)	PALLET LBS	PALLET DIMENSIONS (inches)	PALLET COUNT
.035	1020534	Spool	33	12 x 12 x 4	2376	44 x 31 x 34	72 spools/pallet
.045	1020533	Spool	33	12 x 12 x 4	2376	44 x 31 x 34	72 spools/pallet
.035	1010914	Spool	44	12 x 12 x 4	2640	44 x 27 x 34	60 spools/pallet
.045	1010915	Spool	44	12 x 12 x 4	2640	44 x 27 x 34	60 spools/pallet
.035	1010916	Drum	550	21 dia. x 32 tall	1100	42 x 36 x 21	2 drums/pallet
.045	1010918	Drum	550	21 dia. x 32 tall	1100	42 x 36 x 21	2 drums/pallet

### National Standard Customer Service:

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