

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
AWS MINIMUM	70,000	58,000	22	20 ft-lbf

*Typical conducted with CO₂ 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 ₂	100-150-250	18-19-22	80-100-150
	0.035		Spray	90% Argon/ 10% CO ₂	375-500-600	27-30-30	195-210-250
	0.045		Short Circuit	100% CO ₂	125-150-200	19-20-21	145-145-175
	0.045		Spray	90% Argon/ 10% CO ₂	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
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.)

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

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