

FUSION 6 ER70S-6

MIG/MAG Welding Wire



- **High Manganese / Silicone Wire For GMAW (MIG) Welding of Mild & Low Alloy Steels.**
- **Argon (M21) and C1 (CO₂) Shielding Gases.**

DESCRIPTION & APPLICATION:

Corefab® Fusion 6 is a premium quality copper coated welding wire designed for (GMAW) / (MIG) welding of 500MPa carbon steel and low alloy steels, using CO₂ or Ar/Mix gases. An all positional welding wire designed for general industry for steel fabrication, including Machinery, ships, vehicles, petrochemical and other industries.

Precision layer-wound spooling and high-quality copper coating ensuring smooth stable feedability and reliable welding performance during operation. Its higher silicon content delivers minimal spatter levels, an attractive weld bead appearance, and optimal side wall fusion, making it suitable for both productivity and visual weld quality.

STORAGE:

To maintain premium condition, product should be stored in their original packaging in a controlled environment of less than 50% relative humidity. Avoid damp, wet areas.

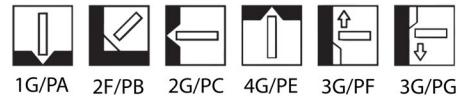
CLASSIFICATIONS:

- AWS A5.18 ER70S-6
- EN ISO 14341-A: G 42 4 C1/M21 3Si1
- EN ISO 14341-B: G 49 4 C1/M21 S6

APPROVALS:

- ABS: 3YSA/4YSA ■ DB: G 42 4 C1/M21 3Si1
- DNV: III YMS ■ TUV: G 42 4 C1/M21 3Si1
- CO₂ Only: ■ CWB: B-G 49A 3 C1 S6

POSITIONS:



TYPICAL ALL WELD METAL CHEMICAL ANALYSIS:

C	Si	Mn	P	S	Ni	Cr
0.08	0.89	1.50	0.012	0.013	0.07	0.02
Mo	V	Cu	Al	Ti+Zr		
0.012	0.010	0.11	0.011	0.12		

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS:

	ISO 14175:	M21	C1
Yield Strength (Mpa)		467	452
Tensile Strength (Mpa)		585	568
Elongation (%)		28	28
CVN Impact Value (J)		133 @ -20°C	115 @ -20°C
		87 @ -40°C	71 @ -40°C

PACKAGING DATA

WIRE DIAMETER	PACK SIZE & TYPE	PART NUMBER
0.8mm	5KG Spool	MWCF0805
0.9mm	5KG Spool	MWCF0905
0.8mm	15KG Spool	MWCF0815
0.9mm	15KG Spool	MWCF0915
1.0mm	15KG Spool	MWCF1015
1.2mm	15KG Spool	MWCF1215

OPERATIONAL INFORMATION

WIRE DIAMETER	WELDING CURRENT RANGE	ARC VOLTAGE RANGE*	TYPICAL STICKOUT	GAS FLOW RATE
0.8mm	35 - 180A	16 - 26V	9 - 12mm	9 - 15L/min
0.9mm	80 - 275A	17 - 30V	10 - 13mm	12 - 15L/min
1.0mm	90 - 285A	18 - 28V	13 - 15mm	12 - 15L/min
1.2mm	145 - 340A	19 - 30V	15 - 20mm	12 - 20L/min

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