

# JACKSUN MIG-70S2

COPPER COATED CONTINUOUS OR CUT LENGTH  
SOLID WIRE FOR TIG/MIG WELDING

BASIC ALLOY: FE, MN, SI WITH  
TRIPLE OXIDE

AWS: SFA/A 5.18: ER70S-2  
EN ISO 14341-B G 49A 3 C/M S6

## KEY FEATURES:

Copper coated Triple oxidized solid mild steel wire, smooth flow, stable arc and minimum spatter under optimum welding conditions. Gives radiographic quality welds.

## APPLICATIONS

- structural steel
- pressure vessels and boilers
- micro alloyed structural steels with specified tensile strength up to 520 N/mm<sup>2</sup> to meet sub-zero impact requirements down to -51°C.

## SHEILDING GAS:

- MIG welding with CO<sub>2</sub> gas and Ar+ CO<sub>2</sub> gas mixture, TIG welding with Argon gas

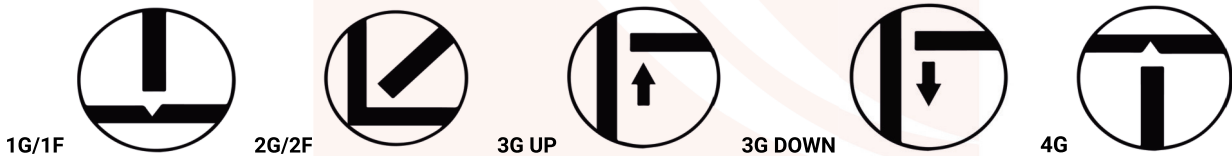
## CHEMICAL COMPOSITION:

| C        | Mn        | Si        | S         | P         | Cu       | Ti        | Zr        | Al        |
|----------|-----------|-----------|-----------|-----------|----------|-----------|-----------|-----------|
| 0.07 max | 0.90-1.40 | 0.40-0.70 | 0.035 Max | 0.025 Max | 0.50 Max | 0.05-0.15 | 0.02-0.12 | 0.05-0.15 |

## MECHANICAL PROPERTIES:

| YS (N/mm <sup>2</sup> ) | UTS (N/mm <sup>2</sup> ) | EL % (l=5d) | CHARPY "V" NOTCH<br>IMPACT @ |
|-------------------------|--------------------------|-------------|------------------------------|
| 420 Min.                | 510 Min.                 | 22.0 Min.   | Minus 30C : 27 J Min         |

## WELDING POSITION



## DIEMENSION, CURRENT CONDITION & PACKING DATA

| Size (mm) | Size (inch) | Length (mm) | Length (Inch) | Current Condition (DC+) | Voltage (V) | Tube packing 5 kg | Box packing 20 kg |
|-----------|-------------|-------------|---------------|-------------------------|-------------|-------------------|-------------------|
| 1.60      | 1/16"       | 1000        | 36"           | 40-80                   | 10-16       | ✓                 | ✓                 |
| 2.0       | 5/64"       | 1000        | 36"           | 50-100                  | 12-18       | ✓                 | ✓                 |
| 2.4/ 2.5  | 3/32"       | 1000        | 36"           | 60-120                  | 14-20       | ✓                 | ✓                 |
| 3.2       | 1/8"        | 1000        | 36"           | 100-150                 | 16-24       | ✓                 | ✓                 |
| 4.0       | 5/32"       | 1000        | 36"           | 140-200                 | 18-28       | ✓                 | ✓                 |