



# EAGLE E70S-6

*Copper Coated Gas Shielded All Position Wire  
For Joining Low Carbon Steel.*

**CONFORMS TO AWS A5.18 CLASS ER70S-6**

## **APPLICATIONS**

This wire is used for general welding of mild steel and low carbon steels. The Eagle 70S-6 designed for welding duct work, structural steel, machinery, sheet plate and general repair work on low carbon steel components using single or multi pass welds.

## **PROCEDURE**

DC Reverse [+] Polarity. Use the grinding method or remove fatigued metal using the **EAGLE 188**. Use the lowest effective amperage while maintaining a 1/4 - 1/2 inch stick out length. Use the stringer bead technique for maximum strength.

## **GENERAL CHARACTERISTICS**

The **Eagle 70S-6** is an all position copper coated wire designed to produce superior weldments using mixed gas (80% Argon / 20% CO) or 100% CO<sub>2</sub> shielding gas. This wire is suitable for high speed welding of low carbon steel by short circuit transfer mode for welding in all position.

## **TECHNICAL DATA**

Tensile Strength: Approx. 81,000 psi – 84,000 psi  
Yield Strength: Approx. 71,000 psi – 75,000 psi  
Elongation: Approx. 30%  
Current: DC Reverse [+] Polarity

## **WELDING PARAMETERS**

Sizes:	Inches	0.35	0.45
	mm	0.90	1.20
Volts:		15 - 19	17 - 19
Amperage:		100 - 160	160 - 220
Gas Flow:		30 – 40 CFH	
Shielding Gas:		75/25% AR/CO <sub>2</sub> 80/20% AR/CO <sub>2</sub> or 100% CO <sub>2</sub>	



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