

# GM 70

## CLASSIFICATION:

AWS/SFA 5.18: ER70S-6C, JIS Z3312 YGW12, IS 814: 2004

## CHARACTERISTICS:

GM 70 is copper coated solid wire designed for all position welding by short-circuiting type transfer. As the deposition efficiency is high and penetration is deep, highly efficient welding can be performed. The wire is supplied in precision layer winding on plastic spool.

## CHEMICAL COMPOSITION OF THE WIRE (%)

C	Mn	Si
0.06-0.15	1.40- 1.85	0.80-1.15
S	P	Cu
0.025 max	0.035 max	0.4 max

## TYPICAL APPLICATION:

- Butt & fillet welding of steel structures such as vehicles, machinery & bridges etc.
- ASTM A210 GrA1,C, A36,A106GrA/B/C,A139,A214,A234
- Trailers, earth, moving equipments.
- Bus bodies, containers.
- Railway wagons, storage tanks.
- Ship building, pipe welding.
- The sheet welding in automotive industry.

## TYPICAL MECHANICAL PROPERTIES OF ALL-WELD METAL

UTS (MPa)	YS (MPa)	Elongation (%)	CVN Impact in Joules	
			Temp	Value
540	430	28	-29°C	60-90

## INSTRUCTION ON USAGE:

- Use welding grade CO<sub>2</sub>/Argon +15~25% CO<sub>2</sub> gas mixture.
- Flow quantity of shielding gas should be 25 l/min. approximately.
- Use wind screen against wind.
- Keep distance between tip and base metal for more than 250A of welding current. 6~15mm for less than 250A, and 15~25mm

## Recommended Current (Amps):

Size(mm)	0.8mm	1.20mm	1.6mm
F, HF	50-220	100-320	170-390
V up, OH	50-140	50-140	Not recommended

## PACKING DATA:

Size (mm)	Spool (Kgs.) (Nett Wt)
0.8	15
1.2	15
1.6	15

## Manufactured by: GEE LIMITED

Regd. Off & Works: plot No.B - 12, MIDC, Kalyan-Bhiwandi Road, Saravli, Kalyan (West) Thane, Maharastra, India.  
Website: www.geelimited.com

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