

# UltraWeld

APPROVAL:



CLASSIFICATION: AWS : AS. 18. ER. 70S-6

IS: 6419.S.4

DIN: 8559.SG2

## APPLICATION

- Automobile Body, Chassis, Frames and Brackets
- Automobile Silencers, Petrol/Diesel/Gas Tanks all other Automobile, Scooter, Cycle spare parts and accessories
- LPG Gas Cylinders, Compressors, Railway Wagons, Boilers, Poles & Steel Towers
- Steel Furniture, scaffoldings & all other welding in general steel fabrication

## WIRE ANALYSIS %:

C%	Mn%	Si%	S%	P%
0.08	1.50	0.80	0.015	0.017

## MECHANICAL PROPERTIES IN WELD METAL: SHIELDING GAS-100% Co2:

	YIELD STRENGTH	TENSILE STRENGTH	ELONGATI ON L=5Xd	CHARPY V-NOTCH IMPACT VALUES AT -30°C:	RADIOGRAPHY
	MPa[N/MM <sup>2</sup> ]	MPa[N/MM <sup>2</sup> ]	%	JOULES	
Actual value	467	571	26.80	80,88,72,76,90 AVG.: 81.33	SATISFACTORY
Specn. value	420 MINIMUM	500-640	22 MINIMUM	AVG. 27 JOULES MINIMUM	

## WELDING CURRENT DC (+) :

Wire Size (mm)	0.80	1.00	1.20	1.60
AMP	50,160	80,200	1,10,250	200-400