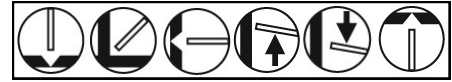


Quantum Arc™ 6



AWS ER70S-6

WELDING POSITIONS:



FEATURES:

- Excellent feedability
- Consistent feeding
- Excellent wetting characteristics
- High in deoxidizers

BENEFITS:

- Greater productivity
- Increased consumable life and feeds well through longer gun cables
- Smooth weld beads with uniform tie-in
- Best choice for rusty and oily plates

APPLICATIONS:

- Automotive frames
- Construction equipment
- Rail cars
- Farm implements
- Pressure vessels
- Pipe and tubing
- Non-alloyed and fine grain steels
- Robotic, automatic, and semi-automatic welding

SHIELDING GAS: 100% Carbon Dioxide (CO₂), 75-92% Argon (Ar)/Balance Carbon Dioxide (CO₂), 25-50 cfh (12-24 l/min)

TYPE OF CURRENT: Direct Current Electrode Positive (DCEP)

STANDARD DIAMETERS: 0.035" (0.9 mm), 0.045" (1.2 mm)

RE-DRYING: Not recommended

STORAGE: Product should be stored in a dry, enclosed environment, and in its original intact packaging.

TYPICAL CHEMICAL VALUES*:

Weld Metal Analysis	Wire Melt Button	AWS Wire Spec
Carbon (C)	0.10	0.06-0.15
Manganese (Mn)	1.43	1.40-1.85
Silicon (Si)	0.83	0.80-1.15
Phosphorus (P)	0.007	0.025 max
Sulphur (S)	0.005	0.025 max
Copper (Cu)	0.20	0.50 [†] max

[†] Copper content of wire and copper coating.

TYPICAL MECHANICAL PROPERTIES* (As Welded):

Mechanical Tests	100% CO ₂	AWS Spec
Tensile Strength	88,000 psi (607 MPa)	70,000 psi (480 MPa) Minimum
Yield Strength	75,000 psi (507 MPa)	58,000 psi (400 MPa) Minimum
Elongation % in 2" (50 mm)	26%	22% Minimum

TYPICAL CHARPY V-NOTCH IMPACT TEST RESULTS* (As Welded):

CVN Temperatures	100% CO ₂	AWS Spec
Avg. at -20°F (-30°C)	73 ft•lbs (99 Joules)	20 ft•lbs (27 Joules) Minimum

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Hobart Brothers LLC expressly disclaims any liability incurred from any reliance thereon. Typical data are those obtained when welded and tested in accordance with the AWS A5.18 specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique not controlled by Hobart Brothers LLC.

Quantum Arc™ 6

Diameter		Transfer Mode	Amps	Volts	Wire-Feed Speed		Deposition Rate		Contact Tip to Work Distance	
Inches	(mm)				in/min	(m/min)	lbs/hr	(kg/hr)	Inches	(mm)
0.035	(0.9)	Short-Circuit	105	16.5	175	(4.4)	2.9	(1.3)	1/2	(13)
0.035	(0.9)	Short-Circuit	110	17.5	190	(4.8)	3.1	(1.4)	5/8	(16)
0.035	(0.9)	Short-Circuit	115	18.5	210	(5.3)	3.4	(1.5)	5/8	(16)
0.035	(0.9)	Short-Circuit	125	19.5	230	(5.8)	3.8	(1.7)	5/8	(16)
0.035	(0.9)	Short-Circuit	130	20.5	250	(6.4)	4.1	(1.9)	5/8	(16)
0.035	(0.9)	Spray	170	25.0	360	(9.1)	5.8	(2.6)	5/8	(16)
0.035	(0.9)	Spray	180	26.0	410	(10.4)	6.7	(3.0)	5/8	(16)
0.035	(0.9)	Spray	200	27.5	500	(12.7)	8.0	(3.6)	3/4	(19)
0.035	(0.9)	Spray	240	29.0	700	(17.8)	11.2	(5.1)	3/4	(19)
0.045	(1.2)	Short-Circuit	130	18.0	140	(3.6)	3.8	(1.7)	5/8	(16)
0.045	(1.2)	Short-Circuit	150	19.0	160	(4.1)	4.4	(2.0)	5/8	(16)
0.045	(1.2)	Spray	220	25.0	275	(7.0)	7.5	(3.4)	3/4	(19)
0.045	(1.2)	Spray	250	27.0	325	(8.3)	8.8	(4.0)	3/4	(19)
0.045	(1.2)	Spray	285	28.5	400	(10.2)	10.8	(4.9)	3/4	(19)
0.045	(1.2)	Spray	325	29.0	500	(12.7)	13.7	(6.2)	1	(25)
0.052	(1.4)	Spray	290	27.0	280	(7.1)	9.8	(4.4)	3/4	(19)
0.052	(1.4)	Spray	325	27.0	330	(8.4)	11.6	(5.2)	3/4	(19)
0.052	(1.4)	Spray	390	29.0	420	(10.7)	14.8	(6.7)	3/4	(19)

Note: Short circuit transfer shielding gas is 75% Ar/25% CO₂ at 20-35 cfm (9-17 l/min). For 100% CO₂ shielding gas within the recommended range, increase listed voltages by 1-3 volts.

Note: Spray transfer shielding gas is 90% Ar/10% CO₂ at 35-50 cfm (17-24 l/min)

- **Maintaining a proper welding procedure - including pre-heat and interpass temperatures - may be critical depending on the type and thickness of steel being welded.**
- **For out of position welding, short circuit or pulsed spray transfer modes must be used.**

COMMONLY ORDERED PART NUMBERS

Diameter in. (mm)	33-lb. Steel Reel™	45-lb. Steel	45-lb. Spool	60-lb. Spool	300-lb. Recyclable RoboPak®	600-lb. RoboPak®	600-lb. Recyclable RoboPak®	950-lb. Recyclable RoboPak®
Net Pallet Weight	2376-lb. (1078kg)	3240-lb. (1470kg)	3240-lb. (1470kg)	1920-lb. (871kg)	1200-lb. (544kg)	2400-lb. (1089kg)	2400-lb. (1089kg)	1900-lb. (862kg)
0.035 (0.9)	S307608-033	S307608-045	S307608-085	—	S307608-073	S307608-011	S307608-074	S307608-070
0.045 (1.2)	S307612-033	S307612-045	S307612-085	S307612-028	S307612-073	S307612-011	S307612-074	S307612-070
0.052 (1.4)	—	—	—	S307615-028	—	—	S307615-074	S307615-070

CONFORMANCES AND APPROVALS:

- **AWS A5.18**, ER70S-6
- **AWS A5.18M**, ER48S-6
- **ASME SFA 5.18**, F-6, A-1, ER70S-6
- **CWB B-G 49A 3 C1 S6**

TECHNICAL QUESTIONS? For technical support of Hobart Filler Metals products, contact the Applications Engineering department by phone toll-free at 1-800-532-2618 or by e-mail at Applications.Engineering@hobartbrothers.com

CAUTION:

Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standard Z49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36th St., Miami, FL 33166 (can also be downloaded online at www.aws.org); OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210

Safety Data Sheets on any Hobart Brothers LLC product may be obtained from Hobart Customer Service or at www.hobartbrothers.com.

Because Hobart Brothers LLC is constantly improving products, Hobart reserves the right to change design and/or specifications without notice.

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Revision Date: 220609(Replaces 210824)
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