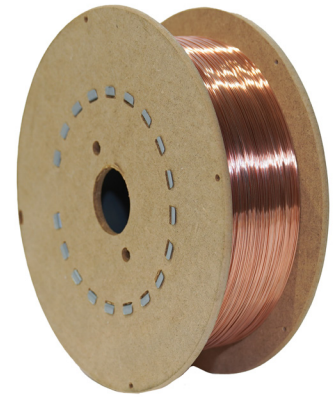


Copper-Glide™ NS-115 Copper-Coated Welding Wire

AWS ER70S-6



Copper-Glide™ NS-115 Copper-Coated Welding Wire is a premium copper-coated mild steel solid filler metal containing a high combined total of manganese and silicon.

The wire produces a smooth, uniform welding arc, which minimizes weld spatter and results in excellent bead appearance and high operator appeal. The excellent operating characteristics appeal to users seeking better performance in their ER70S-6 applications.

Manufacturing Advantages

- All metal transfer modes of GMAW
- Robotic, mechanized, or semi-automatic welding
- Welding steel with medium to heavy mill scale, light rust, or thin oil
- Single and multi-pass weldments
- Applications requiring a minimum 70,000 psi tensile strength
- Suitable for a broad range of fabrication and construction projects
- Good feedability and uniformity for consistent feed rate and uniform weld bead appearance
- Improved fusion and reduced risk of defects with minimal porosity

Welding Positions

All position welding is possible when using the correct shielding gas blends, welding process, and welding parameters.

Shielding Gas Blends

- 100% CO₂
- 75-95% Argon/Balance CO₂
- 95-98% Argon/Balance O₂
- Flow rate of 35-50 CFH

Applications

- Agricultural Equipment
- Auto Body
- Automotive Exhaust
- General Fabrication
- Heavy Equipment
- Pipe Welding
- Pressure Vessels
- Railcars
- Shipbuilding
- Structures
- Trailers

Specifications

Meets or Exceeds:

- AWS A5.18/A5.18M: ER70S-6 H4
- ASME SFA-A5.18: ER70S-6
- AWS A5.17: EH11K
- ABS
- CWB W48: B-G 49A 3 C1 S6

Storage

Welding wire should be stored in a dry, enclosed environment and in its originally sealed package.

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Typical Mechanical Properties (as welded)

Certified As	TENSILE STRENGTH PSI	YIELD STRENGTH PSI	MINIMUM ELONGATION %	CVN IMPACT VALUES @ 20° F
NS Plus -115	82,200	65,200	29	60 ft-lbf
NS 115 CopperFree™	88,800	73,500	27	39 ft-lbf
AWS MINIMUM	70,000	58,000	22	20 ft-lbf

Typical Wire Chemistry Percentages (as required per AWS)

Certified As	C	Mn	Si	P	S	Cu	Ni	Cr	Mo	V
NS Plus® -115 Typ.	0.08	1.49	0.9	0.01	0.01	0.14	0.05	0.04	0.008	0.006
NS 115 CopperFree™ Typ.	0.09	1.52	0.91	0.011	0.011	0.07	0.06	0.06	0.01	0.01
AWS A5.18/A5.18M	0.06/0.15	1.40/1.85	0.80/1.15	0.025 (max.)	0.035 (max.)	0.50 (max.)	0.15 (max.)	0.15 (max.)	0.15 (max.)	0.03 (max.)
AWS A5.17/A5.17M	0.06/0.15	1.40/1.85	0.80/1.15	0.030 (max.)	0.030 (max.)	0.35(max.)				



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