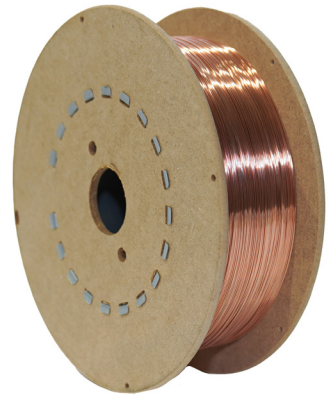


# Copper-Glide™ NS-115US Copper-Coated Welding Wire

**AWS ER70S-6**



Copper-Glide™ NS-115US Welding Wire is a premium copper-coated mild steel solid filler metal. It delivers superior results for every weld and ensures a smooth and uniform welding arc, minimizing spatter and achieving excellent bead appearance for ER70S-6 applications.

The welding wire exhibits excellent feedability, precise wire positioning, and higher silicon content for flatter bead profiles.

**100% Made in the U.S.A. with American steel to meet "Buy America" Standards.**

## 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
- Good feedability and uniformity for consistent feed rate and uniform weld bead appearance
- Lower hydrogen content for reduced risk of hydrogen-induced cracking in the welds

## Welding Positions

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

## Shielding Gas Blends

- 100% CO<sub>2</sub>
- 75-95% Argon/Balance CO<sub>2</sub>
- 95-98% Argon/Balance O<sub>2</sub>
- 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-5.18: ER70S-6
- AWS A5.17: EH11K
- ABS

✓ Made in the USA

- Mil-E-273765/1: MIL-70S-6
- 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.



3602 North Perkins Road  
Stillwater, OK 74075  
Customer Service: 1-800-777-1618  
www.NSARC.com



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

**AWS ER70S-6**

## 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
<b>AWS MINIMUM</b>	<b>70,000</b>	<b>58,000</b>	<b>22</b>	<b>20 ft-lbf</b>

## 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	0.011	0.01	0.14	0.05	0.04	0.008	0.006
NS 115 CopperFree™ Typ.	0.09	1.52	0.91	0.012	0.011	0.07	0.06	0.06	0.01	0.01
<b>AWS A5.18/A5.18M</b>	<b>0.06/0.15</b>	<b>1.40/1.85</b>	<b>0.80/1.15</b>	<b>0.025 (max.)</b>	<b>0.035 (max.)</b>	<b>0.50 (max.)</b>	<b>0.15 (max.)</b>	<b>0.15 (max.)</b>	<b>0.15 (max.)</b>	<b>0.03 (max.)</b>
<b>AWS A5.17/A5.17M</b>	<b>0.06/0.15</b>	<b>1.40/1.85</b>	<b>0.80/1.15</b>	<b>0.030 (max.)</b>	<b>0.030 (max.)</b>	<b>0.35(max.)</b>				



3602 North Perkins Road  
Stillwater, OK 74075  
Customer Service: 1-800-777-1618  
www.NSARC.com