

Viking™ Copper-Coated Welding Wire

AWS ER70S-6



Viking™ is a premium copper-coated import MIG welding wire that is well-suited for general GMAW welding applications. (Sold only in pallet quantities.)

It is excellent for welding steel with mill scale, rust or oil and is designed for single and multi-pass welding applications.

Manufacturing Advantages

Well-suited for these applications:

- General GMAW applications
- Welding steel with mill scale, rust, or oil
- Single to multi-pass welding applications
- MIG (Metal Inert Gas)
- MAG (Metal Active Gas)
- For DC+ CC/CV
- Low carbon killed and semi killed steel
- Robotic, mechanized, or semi-automatic welding
- Applications requiring a minimum 70,000 psi tensile strength
- Improved mechanical properties for various applications

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:

- ER70S-6 (AWS A5.18, ASME SFA-A5.18)
- 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



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Typical Mechanical Properties (as welded)

	TENSILE STRENGTH PSI	YIELD STRENGTH PSI	MINIMUM ELONGATION %	CVN IMPACT VALUES @ 20° F
ER70S-6 Typical*	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)

	C	Mn	Si	P	S	Cu	Ni	Cr	Mo	V
ER70S-6 Typical*	0.07	1.45	0.85	0.020	0.025	0.07	0.06	0.06	0.01	0.01
AWS A5.18	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.)

Packaging Dimensions

DIAMETER	PART #	PKG	LBS	PKG DIMENSIONS (in.)	PALLET LBS	PALLET DIMENSIONS (in.)	PALLET COUNT
0.035	1020534	Spool	33	12 x 12 x 4	2376	44 x 31 x 34	72 spools/pallet
0.035	1010914	Spool	44	12 x 12 x 4	2640	44 x 27 x 34	60 spools/pallet
0.045	1010915	Spool	44	12 x 12 x 4	2640	44 x 27 x 34	60 spools/pallet
0.035	1010916	Drum	550	21 dia. x 32 tall	1100	42 x 36 x 21	2 drums/pallet
0.045	1010918	Drum	550	21 dia. x 32 tall	1100	42 x 36 x 21	2 drums/pallet



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