



TENSAWELD WORKMATE

FOR JOINING MATERIAL

DESCRIPTION

- Steel welding wire that contains **higher levels of Manganese and Silicon** than other standard grades of MIG wire to produce high quality welds when used on various grades of low carbon steel
- High silicon content increases the fluidity of the weld pool, thus creating a smoother bead appearance and resulting in minimal post-weld grinding
- Engineered to provide porosity-free, x-ray quality welds at the highest tensile strength (as welded) of all the plain carbon steel wires
- 100% compatibility with Tensalloy™ products

CONDITIONS OF USE

Current Type	Welding Position
DCEP	F, V, OH, H

TENSILE, YIELD & ELONGATION

Tensile Strength (kpsi)	70
Yield Strength (kpsi)	58
Elongation in 2" %	22

RECOMMENDED WELDING PARAMETERS

Diameter		Process	Volt	Travel Speed (ipm)	Amps	Shielding Gas
in.	mm					
0.045	1.2	GMAW	23-29	12-21	170-375	Spray transfer 98% Ar + 2% Oxygen
1/16	1.6	GMAW	25-31	9-19	275-475	

Notice: The results reported are based upon testing of product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results may differ. Consult with us for specific compatibility information.

TYPICAL WELD DEPOSIT CHEMISTRY (CO₂)

C	0.06-0.15
Mn	1.40-1.85
Si	0.80-1.15
P	0.025
S	0.035
Ni	0.15
Cr	0.15
Mo	0.15
V	0.03
Cu	0.50

CLASSIFICATION

ER70S6
ASME SFA A5.18

COMPATIBILITY

Tensalloy™ AR400
Tensalloy™ AR450
Tensalloy™ AR500
Tensalloy™ Extra HY 80
Tensalloy™ 4150 Steel Bar
Clif-Clad® Overlay Steel Base Plate
AR250, A514

APPLICATIONS

Mining Equipment
Crushing Equipment
Construction Equipment
Seam Welding/Plug Welding
General Fabrication of Tensalloy™



**THIS IS WHAT YOU WANT
TO WELD TENSALLOY
EFFECTIVELY**

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