

Autocraft Copper Coated Solid Steel Welding Wires

Autocraft LW1-6



- A higher manganese/silicon steel wire for GMA Welding
- Use with CO₂ and Argon based shielding gases
- Wide range of minispool, handispool and Autopak packaging options
- Suitable for the positional Gas Metal Arc Welding (GMAW) of mild and low alloy steels, used in general fabrication and structural work.

Classifications:

AS/NZS 2717.1: ES6-GC/M-W503AH.
AWS/ASME-SFA A5.18: ER70S-6.

Packaging and Operating Data:

Wire Dia mm	Voltage Range (volts)	Wire Feed Speed (metres/min)	Current Range (amps)	Pack Type*	Pack Weight	Part No
0.6	12 – 14	3.5 – 14	35 – 100	Mini Spool (4 per pack)	4 x 0.8kg	721104
				Handi Spool	5kg	721108
				Spool	15kg	720103
0.8	14 – 22	3.5 – 14	50 – 180	Mini Spool (4 per pack)	4 x 0.8kg	721105
				Handi Spool	5kg	721109
				Spool	15kg	720114
0.9	15 – 26	3.5 – 15	70 – 230	Spool	15kg	720090
				AutoPak	250kg	720122A
1.0	16 – 29	3.5 – 15	100 – 280	Spool	15kg	720094
				AutoPak	250kg	720123A
1.2	18 – 32	2.5 – 15	120 – 350	Spool	15kg	720096
				AutoPak	250kg	720124A
1.6	18 – 34	2.5 – 10	180 – 390	Spool	15kg	720095
				AutoPak	350kg	720125A

* Mini Spool (ø100mm); Handi Spool (ø200mm); Spool (ø300mm); AutoPak (ø510mm x H.770mm).

AUTOPAK® Parts List:

AUTOPAK accessories "Standard Types".	Part No
Clear plastic AUTOPAK dome (510mm base diam. x 300mm height).	720001
AUTOPAK conduit assembly kit	720008
Robot cell conduit kit	720004

The advantages of AUTOPAK®

- Higher productivity from reduced downtime
- Straight/Twist free wire gives greater accuracy in the joint
- Smaller acceleration weight produces improved arc starting with less stress on wire-feed unite and less slippage and burn backs
- Fully enclosed pack and pay-off system protects against dust, dirt and moisture
- Compact and manoeuvrable makes it easy to use in confined and restricted locations. Autopak takes up only 0.2m² of floor space.

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Welding Grade CO₂: Argon 10-25% CO₂:
Yield Stress 420 MPa 390 MPa
Tensile Strength 520 MPa 500 MPa
Elongation 30% 31%
CVN Impact Val. 110 J @ -20°C 100 J @ -20°C

TYPICAL WIRE ANALYSIS:

C: 0.08% Mn: 1.55% Si: 0.88%
S: 0.010% P: 0.015%

TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

1.0 - 2.0 mls of hydrogen / 100gms of deposited weld metal.

APPROVALS:

L.R.S. Grade 3S, 3YS
A.B.S. Grade 3SA
*Approvals do not include 0.6mm Autocraft LW1-6 wire

RECOMMENDED SHIELDING GAS:

- Argon + 10-15% CO₂ (or equivalent)
- ISO14175: M14, M21, M24
- Argon + 10-25% CO₂ (or equivalent)
- ISO14175: M21
- Argon + 5% CO₂ +3% O₂
- ISO14175: M23
- Welding Grade CO₂
- ISO14175: C1

COMPARABLE CIGWELD PRODUCTS:

Comweld LW1-6 TIG rod
Comweld LW1 TIG rod
Verti-Cor 3XP FCAW
Metal-Cor XP FCAW

