



Premium Quality
MIG Welding Wire



PROSTAR® Premium Quality MIG Welding Wire

PROSTAR Premium Quality MIG welding wires are designed to meet the requirements of the metal fabrication industry, featuring excellent tolerance to rust and scale, excellent wetting characteristics, and a superior arc stability.

Specifications

PROSTAR MIG welding wire exceeds AWS specifications.



ER70S-6 – Designed for superior performance in carbon steel

USA	Canada
AWS 5.18-93	ER480S-6
Class ER70S-6	Certified by CWB to
ASME SFA-5.18	CSA W48.4-95

Minimum Mechanical Properties with CO₂

Tensile Strength	85,000 psi (590 MPa)
Yield Strength	68,000 psi (470 MPa)
Elongation in 2"	29 %
Charpy V-Notch	60 ft/lb @ -20 °F (81 J @ -29 °C)

Typical Wire Chemistry (%)

C	0.06 - 0.12	Mo *	0.15 max.
Mn	1.45 - 1.65	Ni *	0.15 max.
Si	0.80 - 1.00	Ti+Zr *	0.15 max.
P	0.025 max.	Al *	0.020 max.
S	0.025 max.	Fe	Bal
Cu	0.30 max.		

* Total of Cr + Ni + Mo + V shall not exceed 0.50%

Applications

- Heavy equipment
- Structural
- General carbon steel fabrication

ER70S-3 – Designed for killed or semi-killed steel

USA	Canada
AWS 5.18-93	ER480S-3
Class ER70S-3	Certified by CWB to
ASME SFA-5.18	CSA W48.4-95

Minimum Mechanical Properties with CO₂

Tensile Strength	76,000 psi (520 MPa)
Yield Strength	63,000 psi (435 MPa)
Elongation in 2"	29 %
Charpy V-Notch	50 ft/lb @ -20 °F (67 J @ -29 °C)

Typical Wire Chemistry (%)

C	0.06 - 0.12	Mo *	0.15 max.
Mn	1.00 - 1.30	Ni *	0.15 max.
Si	0.50 - 0.70	Ti+Zr *	0.15 max.
P	0.025 max.	Al *	0.020 max.
S	0.025 max.	Fe	Bal
Cu	0.30 max.		

* Total of Cr + Ni + Mo + V shall not exceed 0.50%

Also available...

PROSTAR Twist-Free Robotic Wire

PROSTAR Premium Quality MIG welding wire is also available in twist-free robotic containers up to 1,200 lb (550 kg). It is designed to enhance robot welding performance and reduce operation costs.

PROSTAR MIG Welding Wire – Diameters, Packaging and Part Numbers

PROSTAR MIG welding wires are available in several packaging sizes (2 lb, 12 lb, 33 lb, 44 lb and 60 lb), and in various diameters conveniently designed to fit all needs.

ER70S-6

Wire Dia.	Weight	Part Number
.023"	2 lb	SIDS6RN06B001
.023"	12 lb	SIDS6RN06P006
.023"	33 lb	SIDS6RN06P015
.030"	2 lb	SIDS6RN08B001
.030"	12 lb	SIDS6RN08P006
.030"	33 lb	SIDS6RN08P015
.035"	2 lb	SIDS6RN09B001
.035"	12 lb	SIDS6RN09P006
.035"	44 lb	SIDS6RN09P020
.035"	60 lb	SIDS6RN09P027
.045"	2 lb	SIDS6RN11B001
.045"	12 lb	SIDS6RN11P006
.045"	44 lb	SIDS6RN11P020
.045"	60 lb	SIDS6RN11P027
.052"	60 lb	SIDS6RN13P027

ER70S-3

Wire Dia.	Weight	Part Number
.035"	44 lb	SIDS3RN09P020
.035"	60 lb	SIDS3RN09P027
.040"	44 lb	SIDS3RN10P020
.045"	44 lb	SIDS3RN11P020
.045"	60 lb	SIDS3RN11P027

PROSTAR Premium Quality products are available through Praxair's retail stores.



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