

## Coreweld C6

### Classifications:

AWS A5.18  
CSA W48  
ASME SFA 5.18

E70C-6M  
E491C-6M

### Approvals:

CWB  
ABS  
CSA W48  
3SA, 4YSA

Coreweld C6 was developed and “fine-tuned” especially for hand-held, automatic and robotic welding in the automotive industry, as well as rail car manufacturing, structural welding and other similar applications. Never before has there been such a perfect pairing of filler metal and industry requirements for quality, productivity and profitability.

- Exceptionally high travel speeds, critical for automation
- Enhanced productivity that makes it more cost-effective than solid wires
- Improved feedability and arc stability as a result of special lubricants & surface treatment
- Outstanding deposition efficiencies that can exceed 99% at high travel speeds
- Ideal for flat or horizontal fillet welds, particularly in automated welding
- Handles rust and mill scale with good sidewall tie-in and wetting
- Wide operating parameters
- Excellent restart characteristics
- Very few silicon islands
- Lower spatter levels



**Shielding Gas:** 75/25 Ar/CO<sub>2</sub>, 92/8 Ar/CO<sub>2</sub>

### Typical Mechanical Properties

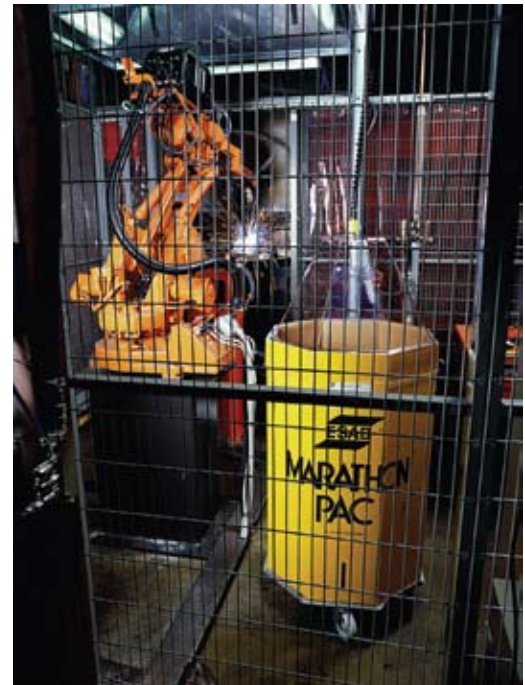
	As Welded 75/25	As Welded 92/8
Yield Strength, psi (MPa)	74,000 (505)	79,000 (545)
Tensile Strength, psi (MPa)	86,000 (595)	86,000 (595)
% Reduction in Area	64.4	63
% Elongation in 2" (51 mm)	27	25

### Typical Charpy V-Notch Impact Properties

Testing Temperature	As Welded ft.-lbs (J) 75/25	As Welded ft.-lbs (J) 92/8
0°F (-18°C)	52 (70)	-
-20°F (-29°C)	38 (52)	56 (76)

### Typical Undiluted Weld Metal Analysis (%)

Gas	C	Mn	Si	P	S
75/25	0.04	1.6	0.7	0.012	0.016
92/8	0.04	1.6	0.8	0.015	0.017



## Deposition Table

Diameter		Amps	Volts	Wire Feed Speed		Deposition Rate		Efficiency %
mm	(in.)			cm/min	(ipm)	kg/hr	(lbs./hr)	
1.2	(0.045)	175	26	592	(233)	2.7	(6.0)	98.4
		200	27	699	(275)	3.2	(7.1)	97.9
		265	28	1067	(420)	5.7	(12.6)	97.2
		330	29	1582	(623)	7.4	(16.4)	98.5
		350	30	1727	(680)	8.4	(18.6)	99.3
1.4	(0.052)	225	23	508	(200)	2.8	(6.1)	87.9
		300	25	762	(300)	4.6	(10.1)	92.1
		370	27	1016	(400)	6.3	(13.8)	97.5
		420	29	1270	(500)	7.8	(17.3)	99.6
		500	31	1524	(600)	9.5	(20.9)	95.3
1.6	(1/16)	270	24	508	(200)	3.9	(8.7)	92.7
		350	27	762	(300)	6.3	(13.9)	97.7
		440	30	1016	(400)	8.7	(19.2)	98.6
		480	31	1270	(500)	10.4	(23.0)	99.6
		500	33	1524	(600)	12.7	(28.0)	99.6

## Standard Part Numbers, Diameters, and Packages

Part Number	Diameter, mm (in.)	Package Weight, Kg (lbs.)	Pallet Weight, Kg (lbs.)
<i>Spools</i>			
243411204	1.2 (0.045)	15 (33)	1080 (2381)
243411162	1.4 (0.052)	15 (33)	1080 (2381)
243411220	1.6 (1/16)	15 (33)	1080 (2381)
<i>Coils</i>			
243411147	1.2 (0.045)	27.2 (60)	870.4 (1919)
243411154	1.4 (0.052)	27.2 (60)	870.4 (1919)
243411022	1.6 (1/16)	27.2 (60)	870.4 (1919)
<i>Jumbo Octagon Marathon Pac (Bulk)</i>			
243411170	1.2 (0.045)	272.2 (600)	544.4 (1200)
243411188	1.4 (0.052)	272.2 (600)	544.4 (1200)
243411196	1.6 (1/16)	272.2 (600)	544.4 (1200)

## Jumbo Octagon Marathon Pac™ Payoff Accessories

Part Number	Description
F103900880	Drum dolly, large, up to 475 Kg
F102537880	Drum lifting device, large, up to 500 Kg
899F135	Payoff hood assembly for Jumbo Drum (includes plastic dome, male conduit quick-connector for dome, and quick-connector kit for wire feeder)
899F84	Heavy Duty Conduit, 3 m (10 ft.)
899F45	Heavy Duty Conduit, 4.5m (15 ft.)
899F85	Heavy Duty conduit, 5 m (20 ft.)



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