

MILD STEEL MIG WIRE

**MERIT™ S-6**

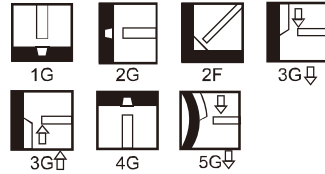


MERIT™ S-6 is a low carbon, high manganese, very high silicon electrode. Used where higher alloy (manganese and silicon) is needed. Allows welding over some rust and dirt. Shielding gases range from CO<sub>2</sub> to high Argon Blends.

### APPLICATION

- Construction Equipment
- Agricultural Equipment
- Automotive
- Ornamental Iron
- Shipping Containers
- Ductwork
- Tubular Framework
- Light to Heavy Structural Steel Fabrication
- Any Application Where a "Finished" Weld Appearance is Desirable

### WELDING POSITIONS



### CONFORMANCE

Conforms to ER70S-6 per AWS A5.18

### APPROVALS

ABS: 3YSA  
DNV: IIIYMS  
CCS: 3YSM

### ADVANTAGES

#### Excellent Welding

- **Characteristics-** MERIT™ S-6 Wire renders good wetting action, straight bead edges, excellent arc action and high resistance to rust or mill scale porosity.
- **Better Wire Feeding-** less down

time, higher productivity-consistently stiff wire, no soft spots. Unique drawing method and special lubricants provide a smooth surface appearance, less friction in the wire feeding system, and elimination of copper coating flaking during wire feeding.

- **More Resistance** to porosity in the weld deposit.
- **Contamination on the wire** surface is minimized in the manufacturing process.
- **Quality Control** of wire chemistry. Each incoming heat of raw material is carefully analyzed. This attention to quality control assures consistent wire chemistry for uniform user results in the field.
- **Manufactured under** a quality system certified to ISO 9001 requirements.

### TYPICAL CHEMICAL COMPOSITION, ALL WELD METAL

%C	%Mn	%Si	%P	%S
0.060	1.13	0.60	0.010	0.008

### MECHANICAL PROPERTIES, ALL WELD METAL

Condition	Tensile Strength (N/mm <sup>2</sup> )	Yield Strength (N/mm <sup>2</sup> )	Elongation (%)	Charpy V-Notch (J) @-29°C
Typical Values	560	450	29	78

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# MERIT™ S-6

## PACKAGING AND AVAILABLE DIAMETERS

Diameter (mm)	Plastic Spools	Drums	Product No.
0.8	15kg	—	CC011301
0.9	15kg	—	CC011302
1.0	15kg	—	CC011303
1.2	15kg	—	CC011304
1.4	15kg	—	CC011331
1.6	15kg	—	CC011305
0.8	—	150kg	CC011306
0.9	—	200kg	CC011307
0.8	—	250kg	CC011333
0.9	—	250kg	CC011308
1.0	—	250kg	CC011309
1.2	—	250kg	CC011310
0.8	—	300kg	CC011335
0.9	—	300kg	CC011311
1.0	—	300kg	CC011312
1.2	—	300kg	CC011313
1.6	—	350kg	CC011314
1.6	—	400kg	CC011315

## RECOMMENDED WELDING CURRENT (DC+)

Diameter (mm)		0.8	0.9	1.0	1.2	1.6
Recommended Current Range (amp)	1G	50-180	50-200	50-220	80-350	170-550
	4G	50-100	50-120	50-120	50-150	—
	3G↑	50-100	50-140	50-140	50-160	—
	3G↓	50-100	50-200	50-200	50-250	—

### Customer Assistance Policy

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customers particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has not been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to change - This information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.com.cn](http://www.lincolnelectric.com.cn) for any updated information.



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