

Table 4
Mechanical Property Requirements for GMAW and GTAW Tests

AWS Classification ^a A5.18 [A5.18M]	Shielding Gas ^{b,c,d}	Tensile Strength ^e ksi [MPa]	Yield Strength ^f (minimum) ksi [MPa]	Elongation ^g Percent (minimum)	Energy Absorbed ^{h,i} (minimum average) A5.18 [A5.18M]
ER70S-2 [ER49S-2]	CO ₂ (C1)	70 [490]	58 [400]	22	20 ft-lbf @ -20°F [27 J @ -30°C]
ER70S-3 [ER49S-3]	CO ₂ (C1)	70 [490]	58 [400]	22	20 ft-lbf @ 0°F [27 J @ -20°C]
ER70S-4 [ER49S-4]	CO ₂ (C1)	70 [490]	58 [400]	22	Not Required
ER70S-6 [ER49S-6] ER70S-7 [ER49S-7] ER70S-8 [ER49S-8]	CO ₂ (C1)	70 [490]	58 [400]	22	20 ft-lbf @ -20°F [27 J @ -30°C]
ER70S-G [ER49S-G]	(j)	70 [490]	58 [400]	22	(j)
Composite Electrodes					
E70C-3C [E49C-3C]	CO ₂ (C1)	70 [490]	58 [400]	22	20 ft-lbf @ 0°F [27 J @ -20°C]
E70C-3M [E49C-3M]	75%–80% Ar/ balance CO ₂ (M21)	70 [490]	58 [400]	22	20 ft-lbf @ 0°F [27 J @ -20°C]
E70C-6C [E49C-6C] E70C-8C [E49C-8C]	CO ₂ (C1)	70 [490]	58 [400]	22	20 ft-lbf @ -20°F [27 J @ -30°C]
E70C-6M [E49C-6M] E70C-8M [E49C-8M]	75%–80% Ar/ balance CO ₂ (M21)	70 [490]	58 [400]	22	20 ft-lbf @ -20°F [27 J @ -30°C]
E70C-12C [E49C-12C]	CO ₂ (C1)	70–90 [490–620]	58 [400]	22	20 ft-lbf @ -20°F [27 J @ -30°C]
E70C-12M [E49C-12M]	75%–80% Ar/ balance CO ₂ (M21)	70–90 [490–620]	58 [400]	22	20 ft-lbf @ -20°F [27 J @ -30°C]
E70C-GX [E49C-GX]	(j)	70 [490]	58 [400]	22	(j)
E70C-GSX [E49C-GSX]	(j)	70 [490]	Not Required	Not Required	Not Required

^a Refer to Figure 1 for an explanation of the classification system.

^b The designations for the shielding gases (in parentheses) are from AWS A5.32M/A5.32.

^c The use of a particular shielding gas for classification purposes shall not be construed to restrict the use of other gas mixtures. A filler metal tested with other gas blends may result in weld metal having different mechanical properties.

^d Testing with 100% Ar shielding is required when classification testing is based upon GTAW only.

^e Tensile strengths are minimum unless specified otherwise.

^f Yield strength measured at 0.2% offset.

^g Percent elongation in 2 in [50 mm] gage length for 1.4 in [36 mm] gage length for the 0.350 in [9.0 mm] tension specimen required in 12.1).

^h For classifications with the "N" (nuclear) optional supplemental designator, three additional specimens shall be tested at a temperature range of 60°F to 90° F [15°C to 32°C]. Two of the three shall equal, or exceed, 75 ft-lbf [100 J], and the third shall not be lower than 70 ft-lbf [95 J]. The average of the three shall equal, or exceed, 75 ft-lbf [100 J].

ⁱ Filler metal classification testing to demonstrate conformance to a specified minimum acceptable level for impact testing, i.e., minimum energy at specified temperature, can be met by testing and meeting the minimum energy requirement at any lower temperature. In these cases, the actual temperature used for testing shall be listed on the certification documentation when issued.

^j Not specified (in agreed upon between purchaser and supplier).

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1. Understanding the eBook 620 32m J 14 Ms
 - The Rise of Digital Reading 620 32m J 14 Ms
 - Advantages of eBooks Over Traditional Books
2. Identifying 620 32m J 14 Ms
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an 620 32m J 14 Ms
 - User-Friendly Interface
4. Exploring eBook Recommendations from 620 32m J 14 Ms
 - Personalized Recommendations
 - 620 32m J 14 Ms User Reviews and Ratings
 - 620 32m J 14 Ms and Bestseller Lists

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 - 620 32m J 14 Ms Budget-Friendly Options
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 - ePub, PDF, MOBI, and More
 - 620 32m J 14 Ms Compatibility with Devices
 - 620 32m J 14 Ms Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of 620 32m J 14 Ms
 - Highlighting and Note-Taking 620 32m J 14 Ms
 - Interactive Elements 620 32m J 14 Ms
8. Staying Engaged with 620 32m J 14 Ms
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers 620 32m J 14 Ms
9. Balancing eBooks and Physical Books 620 32m J 14 Ms
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection 620 32m J 14 Ms
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine 620 32m J 14 Ms
 - Setting Reading Goals 620 32m J 14 Ms
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of 620 32m J 14 Ms
 - Fact-Checking eBook Content of 620 32m J 14 Ms
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning

- Utilizing eBooks for Skill Development
- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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