

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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