

# HUATONG

# HTW-53

AWS ER70S-3

### Typical applications

Butt and fillet welding of transportation vehicles, cars, bridges and industrial machinery.

### Characteristics on Usage

- ▶ Suitable for high speed welding of steel sheet by short circuiting transfer in all position.
- ▶ Stable arc and low spatter loss.
- ▶ Applicable to mixture gas (Ar+20% CO<sub>2</sub>)

### Mild,high tensile steel

GB	AWS	BS EN ISO	shielding gas
ER50-3	ER70S-3	2Si	C1/M21

### Mechanical properties of the deposited metal

Yield Strength MPa	Tensile Strength Mpa	Elongation (%)	Impact J/°C
430	535	33	65/-30

### Chemical composition of the deposited metal (%)

C	Si	Mn	P	S	Mo	Ti
0.08	0.49	1.10	0.015	0.011	-	-

### Application

Mild steel, 490MPa high tension steel, low current.

Item	Unit	D100	D200 Euro	D200 US	D250	D270	D300	K300	S300	250 Drum	350 Drum
Breadth/Height	mm	45	60	55	104	104	104	100	100	810	760
Inner diameter	mm	16	52.5					-	50.5	510	660
Drive hole	mm	-	12					-	-	-	-
Weight fitness	kg	≤1	≤5	≤5	≤15	≤20	≤20	≤20	≤20	≤250	≤410