

SuperArc® L-50®

Mild Steel, Copper Coated • AWS ER70S-3 & EM13K

Key Features

- ▶ Moderate levels of manganese and silicon for deoxidization of clean to light mill scale surfaces
- ▶ Superior feeding and arc stability
- ▶ Copper coated for long contact tip life
- ▶ Supports short-circuiting, globular, axial spray and pulsed spray transfer
- ▶ MicroGuard® Ultra provides superior feeding and arc stability

Typical Applications

- ▶ Clean to light mill scale base material
- ▶ Pipeline
- ▶ Pressure vessels
- ▶ Sheet metal to 380 - 485 MPa (55 - 70 ksi) yield strength material
- ▶ Structural steel

Conformances

AWS A5.18/A5.18M: 2005	ER70S-3
ASME SFA-A5.18:	ER70S-3
AWS A5.17/A5.17M: 1997	EM13K
ABS:	3YSA
Lloyd's Register:	3YS H15
DNV Grade:	III YMS
CWB/CSA W48-06:	ER49S-3
EN ISO 14341-B:	G 49A 2 C S3
MIL-E-23765/1:	MIL-70S-3

Welding Positions

All

Shielding Gas

100% CO₂
 75-95% Argon / Balance CO₂
 95-98% Argon / Balance O₂
 Flow Rate: 30-50 CFH

DIAMETERS / PACKAGING

Diameter in (mm)	33 lb (15 kg) Plastic Spool	33 lb (15 kg) Steel Spool	44 lb (20 kg) Steel Spool	44 lb (20 kg) Fiber Spool	60 lb (27.2 kg) Coil
0.030 (0.8)	ED032923	ED031407			
0.035 (0.9)	ED032924	ED031408	ED031914	ED021268	
0.045 (1.1)	ED032925	ED031409	ED031915	ED021270	
0.052 (1.3)			ED031916		
1/16 (1.6)					ED011317
Diameter in (mm)	60 lb (27.2 kg) Fiber Spool	500 lb (227 kg) Accu-Trak® Drum	500 lb (227 kg) Accu-Pak® Box	600 lb (272 kg) Speed-Feed® Drum	1000 lb (454 kg) Accu-Trak® Drum
0.030 (0.8)		ED029223			
0.035 (0.9)	ED021269	ED021052	ED032899		ED028825
0.040 (1.0)					
0.045 (1.1)	ED021271	ED020526	ED032901		ED028826
0.052 (1.3)	ED021273	ED020527	ED032902		ED029082
1/16 (1.6)	ED027274		ED032903	ED011316	ED029083
Diameter in (mm)	900 lb (408 kg) Accu-Pak® Box	1000 lb (454 kg) Accu-Pak® Box		1000 lb (454 kg) Precise-Trak® Reel	
0.030 (0.8)					
0.035 (0.9)	ED032842				ED032379
0.040 (1.0)					ED032380
0.045 (1.1)		ED032844			ED031614
0.052 (1.3)		ED032845			ED031615
1/16 (1.6)		ED032846			ED033270

WIRE COMPOSITION – As Required per AWS A5.18/A5.18M: 2005

	%C	%Mn	%Si	%S	%P
Requirements - AWS ER70S-3	0.006-0.15	0.90-1.40	0.45-0.75	0.035 max.	0.025 max.
Typical Results⁽³⁾	0.08-0.11	1.14-1.23	0.53-0.59	0.003-0.009	0.003-0.013
	%Cr	%Mo	%Ni	%V	%Cu (Total) ⁽⁴⁾
Requirements - AWS ER70S-3	0.15 max.	0.15 max.	0.15 max.	0.03 max.	0.50 max.
Typical Results⁽³⁾	≤ 0.04	≤ 0.02	≤ 0.03	< 0.01	0.15-0.25

MECHANICAL PROPERTIES⁽¹⁾ – As Required per AWS A5.18/A5.18M: 2005

	Yield Strength ⁽²⁾ MPa (ksi)	Tensile Strength MPa (ksi)	Elongation %	Charpy V-Notch - J (ft•lbf) @ -18°C (0°F) @ -29°C (-20°F)	
Requirements - AWS ER70S-3 As-Welded with 100% CO ₂	400 (58) min.	485 (70) min.	22 min.	27 (20) min.	Not Specified
MIL-70S-3 per MIL-E-23765/1 As-Welded with CO ₂ and 98% Ar/2% O ₂	380-485 (55-70)	485 (70) min.	22 min.	Not Specified	Not Specified
Typical Results⁽³⁾ As-Welded with 100% CO ₂	415 (60)	515 (75)	26	95 (70)	88 (65)
Stress Relieved 1 hr. @ 621°C (1150°F)	365 (53)	475 (69)	34	118 (87)	100 (74)
As-Welded with 75% Ar/25% CO ₂	420 (61)	525 (76)	28	106 (78)	102 (75)
Stress Relieved 1 hr. @ 621°C (1150°F)	365 (53)	490 (71)	33	165 (122)	163 (120)
As-Welded with 90% Ar/10% CO ₂	450 (65)	545 (79)	30	142 (105)	122 (90)
Stress Relieved 1 hr. @ 621°C (1150°F)	365 (53)	485 (70)	35	--	214 (158)
As-Welded with 98% Ar/2% O ₂	425 (62)	540 (78)	27	108 (80)	95 (70)
Stress Relieved 1 hr. @ 621°C (1150°F)	350 (51)	475 (69)	33	--	339 (250)

TYPICAL OPERATING PROCEDURES

Diameter, Polarity Shielding Gas	CTWD ⁽⁵⁾ mm (in)	Wire Feed Speed m/min (in/min)	Voltage (volts)	Approx. Current (amps)	Melt-Off Rate kg/hr (lb/hr)
0.030 in (0.8 mm), DC+					
Short Circuit Transfer 100% CO ₂	9-12 (3/8-1/2)	1.9 (75)	17	35	0.4 (0.9)
		3.8 (150)	18	70	0.8 (1.8)
		7.6 (300)	22	130	1.6 (3.6)
0.035 in (0.9 mm), DC+					
Short Circuit Transfer 100% CO ₂ ⁽⁶⁾	9-12 (3/8-1/2)	2.5 (100)	18	80	0.7 (1.6)
		3.8 (150)	19	120	1.1 (2.4)
		6.4 (250)	22	175	1.8 (4.0)
Spray Transfer 90% Ar/10% CO ₂	12-19 (1/2-3/4)	9.5 (375)	23	195	2.7 (6.0)
		12.7 (500)	29	230	3.6 (8.0)
		15.2 (600)	30	275	4.4 (9.6)
0.045 in (1.1 mm), DC+					
Short Circuit Transfer 100% CO ₂ ⁽⁶⁾	12-19 (1/2-3/4)	3.2 (125)	19	145	1.5 (3.4)
		3.8 (150)	20	165	1.8 (4.0)
		5.1 (200)	21	200	2.5 (5.4)
Spray Transfer 90% Ar/10% CO ₂	12-19 (1/2-3/4)	8.9 (350)	27	285	4.2 (9.2)
		12.1 (475)	30	335	5.7 (12.5)
		12.7 (500)	30	340	6.0 (13.2)
0.052 in (1.3 mm), DC+					
Spray Transfer 90% Ar/10% CO ₂	12-19 (1/2-3/4)	7.6 (300)	30	300	4.8 (10.6)
		8.1 (320)	30	320	5.2 (11.5)
		12.3 (485)	32	430	7.8 (17.1)
1/16 in (1.6 mm), DC+					
Spray Transfer 90% Ar/10% CO ₂	12-25 (1/2-1)	5.3 (210)	25	325	4.8 (10.7)
		6.0 (235)	27	350	5.4 (12.0)
		7.4 (290)	28	430	6.7 (14.8)

⁽¹⁾Typical all weld metal. ⁽²⁾Measured with 0.2% offset. ⁽³⁾See test results disclaimer below. ⁽⁴⁾Copper due to any coating on the electrode plus the copper content of the filler metal itself, shall not exceed the stated 0.50% max. ⁽⁵⁾CTWD (Contact Tip to Work Distance). Subtract 1/4 in (6.4 mm) to calculate Electrical Stickout. ⁽⁶⁾Procedures in these areas are procedures for short circuiting mode using 100% CO₂. When using 75% Argon, 25% CO₂ for short circuit transfer, reduce voltage by 1 to 2 volts.

Material Safety Data Sheets (MSDS) and Certificates of Conformance are available on our website at www.lincolnelectric.com

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

CUSTOMER ASSISTANCE POLICY

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