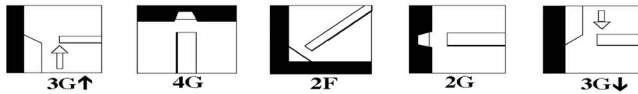




**Welding Postions**



**Accurate Consistent Performance**

UltraMag® S-6 copper coated wire electrode is an all purpose MIG wire for welding fabrication applications where consistent chemical composition, good feeding and reliable performance are required. Sufficient levels of silicon and manganese content allow for welding on base materials with moderate levels of mill scale or low levels of rust or other surface contaminants. Ultra Mag® S-6 is ideal for applications calling for consistent performance in less than ideal conditions. In addition, its S-6 composition allows for a fluid weld puddle, good wash-in at the toes of the weld joint and a flat weld face. Compare these points to the competition - both chemistry and wire diameter are compliant with AS/NZS 2717.1 AWS A5.18 and ASME SFA 5.18 standards because that's what Lincoln customers have come to expect.

**Shielding Gases**

Argon /16%/CO<sub>2</sub>/3% O<sub>2</sub> or equivalent  
 Argon/25% CO<sub>2</sub> or equivalent  
 100% CO<sub>2</sub>  
 Most Argon/CO<sub>2</sub> based gases (contact your local Lincoln supplier for more information)

**Conformance**

AS/NZS 2717.1 ES6-GM/C-W503AH  
 AWS A5.18 ER70S-6

**ADVANTAGE**

✓ **Performance**

S-6 chemical composition delivers a fluid weld puddle, good wash-in at the toes of the weld joint and a flatter weld face.

Dependable feeding is assured through manufacturing process controls that provide consistent surface chemistry and wire diameter.

✓ **Features**

Copper coating provides added electrical conductivity for good arc-starting characteristics and aids in prolonging contact tip life.

✓ **Quality and Reliability**

Chemical analysis and wire diameter tests throughout the manufacturing process assure that UltraMag® S-6 is compliant with AS/NZS 2717.1, AWS A5.18 and ASME SFA 5.18 specifications.

Manufactured under a quality system certified to ISO9001 requirements

**APPLICATIONS**

- ✓ Recommended for mild steel steel all position short circuit transfer welding on sheet metal up to 6mm. Also recommended for spray arc transfer welding on thicker sections of base material.
- ✓ Suitable for welding on mild steel materials under less than ideal conditions, such as moderate levels of mill scale or low levels of rust or other surface contaminants
- ✓ Ideal for workshop fabrication where good electrode feedability and arc characteristics are required.

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**Typical Operating Procedures for UltraMag® S-6**

Diameter, Polarity Electrical stick out Transfer Mode Shielding Gas	Wire Feed Speed		Arc Voltage (volts)	Approx Current (amps)	Melt-Off Rate kg/hr (lbs/hr)
	m/min	(in/min)			
0.9mm (0.35in) DC+	2.5	(100)	16	80	0.7 (1.6)
9-12mm (3/8-1/2in) Dip Transfer	3.8	(150)	17	120	1.1 (2.4)
	6.4	(250)	19	175	1.8 (4.0)
12-19mm (1/2-3/4in) Spray transfer	9.5	(375)	23	195	2.7 (6.0)
	12.7	(500)	29	230	3.6 (8.0)
Ar/10-25% CO <sup>2</sup>	15.2	(600)	30	275	4.4 (9.6)
1.2mm (.045in) DC+	3.2	(125)	17	145	1.5 (3.4)
9-12mm (3/8-1/2in) Dip Transfer	3.8	(150)	18	165	1.8 (4.0)
	5.0	(200)	19	200	2.5 (5.4)
12-19mm (1/2-3/4in) Spray Transfer	8.9	(350)	27	285	4.2 (9.2)
	12.0	(475)	30	335	5.7 (12.5)
Ar/10-25% CO <sup>2</sup>	12.7	(500)	30	340	6.0 (13.2)

**UltraMag® Product Range**

Part Number	Diameter	Type	Weight
AUM0605S6	0.6mm	Spool	5KG
AUM0805S6	0.8mm	Spool	5KG
AUM0905S6	0.9mm	Spool	5KG
AUM0615S6	0.6mm	Spool	15KG
AUM0815S6	0.8mm	Spool	15KG
AUM0915S6	0.9mm	Spool	15KG
AUM1015S6	1.0mm	Spool	15KG
AUM1215S6	1.2mm	Spool	15KG
AUM09250S6	0.9mm	Drum	250KG
AUM12250S6	1.2mm	Drum	250KG
AUM16350S6	1.6mm	Drum	350KG

**Suggested Parameters**

Wire Diameter (mm)	Amps	Volts
<b>Dip Transfer</b>		
0.6	45-90	14-16
0.8	60-140	14-16
0.9	90-160	15-19
1.2	130-200	17-19
<b>Spray Transfer</b>		
0.9	180-230	25-27
1.2	260-340	25-30
1.6	290-400	26-36



**Welding Technology Centre**

If you experience any issues with your UltraMag® S6 wire you can call our Welding Technology Centre.

Our team of welding experts can give you the advice you need to ensure your UltraMag® S6 delivers the perfect weld everytime.

Contact the Welding Technology centre on 1300 546 265 during business hours Monday to Friday.

**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 customer's 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 been given, nor does the provision of information or advice create, expand or

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