

Spoolarc EASY GRIND

Spoolarc Easy Grind is a fully deoxidized wire designed to weld over moderate levels of rust and paint as are commonly encountered in auto body repair work. Easy Grind produces welds that easily exceed the tensile requirements of ER70S class wires. The welded metal is "softer" than most commercial wires. This makes postwork grinding and cleaning easier and faster. Easy Grind is produced in small diameters and are appropriate for the low current welding machines commonly used in the body shops.

Classifications	No AWS Classification
Industry	Industrial and General Fabrication Repair and Maintenance

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
75% Ar - 25% CO₂			
As Welded	497 MPa (72 ksi)	552 MPa (80 ksi)	24 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	-29 °C (-20 °F)	54 J (40 ft-lb)

Deposition Data

Diameter	Current	Deposition Rate	Efficiency %
0.8 mm (.030 in.)	100 A	1.13 kg/h (2.5 lb/h)	93 %
0.8 mm (.030 in.)	100 A	1.18 kg/h (2.6 lb/h)	96 %
0.8 mm (.030 in.)	100 A	1.18 kg/h (2.6 lb/h)	98 %
0.8 mm (.030 in.)	150 A	1.77 kg/h (3.9 lb/h)	93 %
0.8 mm (.030 in.)	150 A	1.81 kg/h (4.0 lb/h)	96 %
0.8 mm (.030 in.)	150 A	1.86 kg/h (4.1 lb/h)	98 %
0.8 mm (.030 in.)	200 A	2.95 kg/h (6.5 lb/h)	93 %
0.8 mm (.030 in.)	200 A	3.04 kg/h (6.7 lb/h)	96 %
0.8 mm (.030 in.)	200 A	6.7 kg/h (6.8 lb/h)	98 %
0.8 mm (.030 in.)	75 A	0.82 kg/h (1.8 lb/h)	93 %
0.8 mm (.030 in.)	75 A	0.86 kg/h (1.9 lb/h)	96 %
0.8 mm (.030 in.)	75 A	0.91 kg/h (2.0 lb/h)	98 %