

ENGINEERED SOLUTIONS



METAL-CORED WIRE LA C-6 LMN



ARCAL™ M14 (ARCAL™ 14)

FIRST IN ITS CLASS

- Gas shielded, metal-cored arc welding (MCAW) electrode with Low Fume and Low Manganese emissions
- Intended to weld with BLUESHIELD™ 8, ARCAL™ M14 (ARCAL™ 14), ARCAL™ SPEED (ARCAL™ 21), ARCAL™ 211 and certain Ar/CO₂ shielding gas blends ranging from 80Ar/20CO₂ to 92Ar/8CO₂
- Exceptional weldability and sound mechanical properties
- Some of the lowest fume generation rates commercially available in low manganese E70C6M wires as specified and tested per AWS F1.2.
- Well suited for structural steel fabrication, farm implement fabrication and general welding applications when concern for reduced weld fume and manganese emissions is priority.

- Optimized blend of Argon with controlled additions of CO₂ and O₂
- Provides a uniform weld bead and good penetration
- The low oxidation potential of ARCAL™ M14 ensures remarkably low fume levels for increased safety in your work environment
- Minimizes spatter levels with less silicate oxides resulting in reduced post-weld cleaning operations
- ARCAL™ M14 can replace Ar/CO₂ and Ar/O₂ mixtures offering more versatility, efficiency and reducing the overall cost of welding
- Optimized performance on thin to medium thickness steel: 14 gauge to 3/8" (2-10 mm)

EXCEPTIONAL RESULTS

Up to 77% lower manganese in weld fumes when used with ARCAL™ M14 (ARCAL™ 14)**

- Up to 77% lower manganese in weld fume when used with ARCAL™ M14 (ARCAL™ 14) as compared to E70C-6M with 75- 80Ar/Balance CO₂ shielding gas.
- Up to 60% lower manganese in weld fume when used with ARCAL™ M14 (ARCAL™ 14) as compared to E70C-6M with 92Ar/8CO₂ shielding gas.

Up to 88% fume reduction when used with ARCAL™ M14 (ARCAL™ 14)**

- Up to 88% fume reduction when used with ARCAL™ 14 as compared to E70C-6M wires welded with 75-80Ar/Balance CO₂ shielding gas.
- Up to 42% fume reduction as compared to E70C-6M wires with the same shielding gas blend 75-80Ar/Balance CO₂.

To support a healthier and safer environment for welders, the LA C-6 LMN achieves significant reduction in fume generation rates.

LA C-6 LMN TYPICAL CHEMISTRY

WEIGHT %	C	Mn	P	S	Si	Ni
BLUESHIELD™ 8	0.06	0.46	0.006	0.010	0.54	0.38
ARCAL™ SPEED (ARCAL™ 21)	0.06	0.58	0.006	0.011	0.69	0.46
ARCAL™ M14 (ARCAL™ 14)	0.07	0.58	0.006	0.011	0.71	0.43
ARCAL™ 211	0.06	0.47	0.006	0.011	0.57	0.38