

SF-70MX

TYPE : Semi-Metal

AWS A5.20 / ASME SFA5.20 E70T-1C
JIS Z3313 T49J 0 T15-0 C A-U H10
EN ISO 17632-A-T 42 0 R C 3

Applications

As a metal cored wire, it is designed for high productive welding of structural steels in excess of 6mm.

Characteristics on Usage

This wire benefits from a high deposition rate with very low spatter loss. It gives excellent penetration and good arc stability.

Notes on Usage

- ① Proper preheating(50~150° C)(122~302° F) and interpass temperature must be used in order to release hydrogen which may cause cracking in weld metal when electrodes are used for medium and heavy plates.
- ② Use 100% CO₂ gas.

Welding Position



1G (PA) 2F (PB)

Current

DC +

Shielding Gas

CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.05	0.50	1.50	0.011	0.010

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
560 (81,300)	590 (85,700)	28	0 (32)	60 (44)

Approval

I Packing(Including Ball Pac)

KR, ABS, LR, BV, DNV, GL, NK, CCS, CCRS, RINA, CWB	Dia. (mm) (in)	1.2 .045	1.4 .052	1.6 1/16	Spool(kg) (lbs)	12.5 28	15 33	20 44
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Sizes Available and Recommended Currents (Amp.)

Size mm(in) F & HF	1.2 (.045) 250~300	1.4 (.052) 300~350	1.6 (1/16) 300~350
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