

# Supercored 70B

TYPE : Basic

AWS A5.20 / ASME SFA5.20 E71T-5M-J  
JIS Z3313 T49 4 T5-1 M A-U H5  
EN ISO 17632-A-T 42 4 B M 3 H5

## Applications

Mild and 490MPa high tensile strength steels for shipbuilding, machinery structures, bridges and heavy plant facilities.

## Characteristics on Usage

Supercored 70B is a basic type flux cored wire with excellent characteristics and is suitable for steel with tensile strength up to 600MPa. Deposited metal shows superior crack resistance, excellent toughness at low temperature of -20~-50° C (-4~-58° F).

## 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 Ar+20~25% CO<sub>2</sub> gas for welding.

## Welding Position



1G 2F 3G 4G  
(PA) (PB) (PF) (PE)

## Current

DC ±

## Shielding Gas

Ar+20~25%CO<sub>2</sub>

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.06	0.43	1.33	0.011	0.013

## Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
450 (65,300)	520 (75,400)	32	-40 (-40)	78 (58)

## Approval

ABS, DNV, BV, GL, LR  
TÜV, DB, CE

## I Packing(Including Ball Pac)

Dia. (mm)	1.0	1.2	1.4	1.6	2.0	Spool(kg)	12.5	15	20
(in)	.039	.045	.052	1/16	5/64	(lbs)	28	33	44

## Sizes Available and Recommended Currents (Amp.)

Size mm(in)	1.0 (.039)	1.2 (.045)	1.4 (0.52)	2.0 (5/64)
F & HF	150~280	170~320	200~350	200~400
V-up,OH	70~130	80~150	90~180	