

Supercored 70MXH

AWS A5.20 / ASME SFA5.20 E70T-1C/-9C
JIS Z3313 T49 2 T15-0 C A-U H5
EN ISO 17632-A-T 42 2 R C 3 H5

TYPE : Semi-Metal

Applications

Supercored 70MXH is a metal cored wire for high speed single or twin tandem welding application in the flat and horizontal fillet position. This wire benefits from high deposition rate and is widely used for shipbuilding, construction of bridge, and structural fabrication.

Characteristics on Usage

Supercored 70MXH has very low spatter loss rate and minimum amount of slag. It gives excellent penetration and good arc stability. Especially has good anti-porosity to zinc-primer plate and mill scale plate in high speed single and twin tandem fillet welding.

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	0.55	1.65	0.013	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)
540 (78,400)	620 (90,000)	28	-20 (-4)	60 (44)

Approval

I Packing(Including Ball Pac)

KR, ABS, LR, BV, DNV, GL,	Dia. (mm)	1.4	1.6	Spool(kg)	15	20
NK, CCS	(in)	.052	1/16	(lbs)	33	44

Sizes Available and Recommended Currents (Amp.)

Size mm(in)	1.4 (.052)	1.6 (1/16)
F & HF	300~400	350~450