

Applications

SF-70W is an all position flux cored wire for use with CO₂ shielding gas. This wire is designed for the welding of weathering grade steels where weld metal and base metal color match is primary consideration.

Characteristics on Usage

SF-70W has a high deposition rate and excellent slag detachability. Its main applications are with 70Kpsi class weather poof steel and construction work using atmospheric corrosion resisting steels.

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 One-side welding defects such as hot cracking may occur with wrong welding parameter such as high welding speed.
- ③ Use 100% CO₂ gas.

Welding Position



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

Current

DC +

Shielding Gas

CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni	Cu
0.04	0.45	1.05	0.017	0.011	0.50	0.35	0.40

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)
510 (74,000)	580 (84,200)	28	0 (32)	60 (44)

Approval

I Packing

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

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.2 (.045)	1.4 (.052)	1.6 (1/16)
F & HF	200~300	250~350	300~400
V-up,OH	120~260	140~270	180~280
V-down	200~300	250~350	300~400