

SC-70H Cored

TYPE : Semi-Metal

AWS A5.20 / ASME SFA5.20 E70T-1C/-9C
JIS Z3313 T49 3 T15-0 C A H10
EN ISO 17632-A-T 42 2 R C 3

Applications

Flat & H-Fillet welding of building, shipbuilding, bridge construction, machinery, vehicle using mild and 490MPa class high tensile steels.

Characteristics on Usage

SC-70H Cored is a flux cored wire for Flat & H-fillet efficient welding with CO₂ shielding gas.

As deposition rate is very high, highly efficient welding can be performed.

Weld metal has good impact properties at -30° C (-22° F).

Slag is uniform and easy to remove.

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)

Current

DC +

Shielding Gas

CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.05	0.56	1.48	0.014	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)
495 (71,900)	580 (84,100)	27	-30 (-22)	51 (37)

Approval

I Packing(Including Ball Pac)

ABS, CCS, LR, GL	Dia. (mm)	1.6	2.0	2.4	Coil(kg)	25
CWB	(in)	1/16	5/64	3/32	(lbs)	55

Sizes Available and Recommended Currents (Amp.)

Size mm(in)	1.6 (1/16)	2.0 (5/64)	2.4 (3/32)
F & HF	300~400	350~450	400~500