

SC-70T Cored

TYPE : Metal-Cored

AWS A5.18 / ASME SFA5.18 E70C-3C / -6M
 JIS Z3313 T 49 2 T15-1 CA
 Z3313 T 49 3 T15-1 MA
 EN ISO 17632-A-T 42 2 M C 1
 ISO 17632-A-T 46 2 M M 1 H5

Applications

SC-70T Cored is ideally suitable for thin plate welding and root pass welding of structural steel. Designed for high productivity and automatic applications where a large amount of filler metal can be deposited with a minimum amount of slag & spatter. Typical industrial applications include shipbuilding, machinery, bridge construction and structural fabrication.

Characteristics on Usage

SC-70T Cored has excellent arc stability and negligible spatter level at not only high current but also low current (down to 50Amp). There is minimum slag coverage so it can be used for multi-pass welding without the need to remove slag.

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 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 or Ar+20~25% CO₂ gas.

Welding Position



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

Current

DC +

Shielding Gas

CO₂/Ar+20~25% CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Shielding Gas
0.06	0.60	1.20	0.011	0.014	100% CO ₂
0.07	0.65	1.45	0.010	0.011	Ar+20~25% CO ₂

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)	Shielding Gas
520 (75,500)	590 (85,700)	27	-20 (-4)	45 (33)	100% CO ₂
550 (79,900)	620 (90,000)	27	-30 (-22)	50 (37)	Ar+20~25% CO ₂

Approval

ABS, BV, DNV, GL, LR
 TÜV, DB, CE

I Packing(Including Ball Pac)

Dia. (mm) 1.2
 (in) .045

Spool(kg) 15
 (lbs) 33

Sizes Available and Recommended Currents (Amp.)

Size mm(in)	1.2 (.045)
F & HF	50~300
V-up,OH	50~160