

SC-70Z Cored

TYPE : Metal-Cored

AWS A5.18 / ASME SFA5.18 E70C-G
EN ISO 17632-A-T 46 Z M M/C 3

Applications

Welding of galvanized steel sheets in the field of automobile manufacturing and galvanized steel in the structure of ships or construction as well.

Characteristics on Usage

SC-70Z Cored is designed for the welding of low carbon and low alloy galvanized steel sheets as well as vertical-up position welding of galvanized pipe line at relatively high weld rates. It has the high deposition rates due to the higher feedability than a solid wire. Applicable to the zinc plating weight less than 60g/m² generally.

Notes on Usage

① Ar + 20~25% CO₂ gas.

Welding Position



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

Current

DC +

Shielding Gas

Ar+20~25%CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Shielding Gas
0.09	0.42	1.35	0.022	0.013	100%CO ₂
0.10	0.61	1.57	0.025	0.014	80%Ar+20%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
550 (79,900)	600 (87,100)	30	0 (32)	120 (89)	100%CO ₂
580 (84,200)	640 (92,900)	25	0 (32)	105 (77)	80%Ar+20%CO ₂

Approval

I Packing(Including Ball Pac)

CWB	Dia. (mm)	1.2	Spool(kg)	12.5	15	20
	(in)	.045		(lbs)	28	33

Sizes Available and Recommended Currents (Amp.)

Size mm(in)	1.2 (.045)	-
F & HF	200~300	-
V-up,OH	100~150	-