

Supercored 70SB

TYPE : Basic

AWS A5.20 / ASME SFA5.20 E71T-5C
JIS Z3313 T49 3 T5-1 C A-U H5
EN ISO 17632-A-T 42 3 B C 2 H5

Applications

Supercored 70SB is suitable for welding of mild and 490MPa high tensile strength steels for shipbuilding, machinery structures, bridge construction and heavy plant facilities.

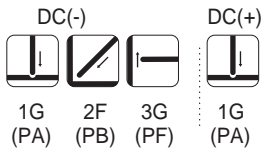
Characteristics on Usage

Supercored 70SB is a basic flux cored wire with excellent characteristics and is suitable for steel with a tensile strength up to 600MPa. Deposited metal shows superior crack resistance, excellent at low temperature at -20~-30° C(-4~-22° F).

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 Designed for use with DC(-).
- ④ Use 100% CO₂ gas.

Welding Position



Current

DC ±

Shielding Gas

CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.06	0.39	1.39	0.013	0.014

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)
DCEN(DC-)	570 (82,800)	620 (90,000)	26	-30 (-22)	70 (52)
DCEP(DC+)	500 (72,600)	550 (79,900)	31	-30 (-22)	80 (59)

Approval

I Packing(Including Ball Pac)

KR, ABS, BV, DNV, GL, LR, NK	Dia. (mm (in)	1.2	1.4	1.6	Spool(kg (lbs)	12.5	15	20
		.045	.052	1/16		28	33	44

Sizes Available and Recommended Currents (Amp.)

Size mm(in)	1.2 (.045)	1.4 (.052)	1.6 (1/16)
F & HF	170~320	200~350	200~350
V-up	80~150	90~180	90~180