

Supershield 4

TYPE : Self-Shielded

AWS A5.20/ ASME SFA5.20 E70T-4
EN ISO 17632-A T 42 Z Z W N 3

Applications

Only Flat, H-Fillet welding of general fabrication, structural fabrication, machinery bases and heavy equipment repair.

Characteristics on Usage

Supershield 4 is self-shield flux cored wire for high deposition rate flat and horizontal welding where impact properties are not required.

Notes on Usage

① Do not use shielding gas.

Welding Position



1G (PA) 2F (PB)

Current

DC +

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Al
0.19	0.38	0.40	0.012	0.010	1.25

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)
465 (67,400)	610 (88,400)	24.0

Approval

I Packing

Dia. (mm)	2.0	Spool(kg)	12.5
Dia. (mm)	2.4	Coil(Kg)	25

Sizes Available and Recommended Currents (Amp.)

Size mm	2.0	2.4
F & HF	250~350	250~450