

OA S-70-T4R

CATEGORY FCAW Flux-Cored

TYPE Welding wire developed for welding without protective gas with high deposition rate.

APPLICATIONS Welding outside in case high speed welding is required and protective gas is not possible or difficult. Suitable for C-Mn steels such as rails, fabrication of machinery, steel framed buildings and or heavy equipment repair. Recommended for butt assembly of rails and crossings.

PROPERTIES

- Very good welding characteristics and not sensitive for contaminations.
- Good mechanical properties and high crack resistance.
- Deposition rate up-to 20 kg/h.
- For single and multiple-pass welding of C-Mn steels.
- Excellent self shielding properties.

CLASSIFICATION AWS A 5.20: E 70 T-4
EN ISO 758: T 38 Z WN 3

SUITABLE FOR Rebuilding and joining steel parts that requires good strenght and high productivity.

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	Al	S	P
0.20	0.55	0.20	1.30	0.002	0.002

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	450	610	25				

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	spools type	kg / spools
1.6	19-27	150-280	BS-300 / Coil / Drum	25 / 330
2.0	25-32	200-400	BS-300 / Coil / Drum	25 / 330
2.4	26-34	300-500	BS-300 / Coil / Drum	25 / 330

REDRYING TEMPERATURE 150°C / 24hr.

NOTE Weld metal toughness has to be considered.