

Coreweld 70

AWS A5.18 E70C-6M / JIS Z3313 T490T15-0C(M)A-U

Description

- Coreweld 70 is a tubular electrode that combines the high deposition rates of a flux cored electrode with the high efficiencies of a solid wire. The fluxing ingredients have been virtually eliminated from the core of this wire, and replaced with metal powder, placing deposition rates consistently within the 11 to 20 lbs./hr. range. The high (90 to 97%) efficiencies reflect the smooth spray transfer and the very low levels of spatter and fumes. The only slag formed by this wire consists of small islands of silicates, and multiple pass deposits can be made without deslagging. Other distinguishing features include excellent wetting action that surpasses that of solid wires at high amperages, and a very good bead profile.
- Coreweld 70 electrodes are designed to weld low and medium carbon steels in the flat and horizontal positions, although the small diameters (.035", .045") (0.9mm, 1.2mm) are capable of operating in all positions. With its low slag and high efficiencies, Coreweld 70 is especially suited for robotic welding.

Flux
CORED
WIRES

Shielding Gas : 100%CO₂ or 75%Ar/25%CO₂

Typical Mechanical Properties of All Weld Metal

Shielding Gas	Yield Point N/mm ² {kgf/mm ² }	Tensile Strength N/mm ² {kgf/mm ² }	Elongation (%)	Impact Value J(kgf · m)		
				0 °C	-20 °C	-30 °C
100%CO ₂	469 {48}	552 {56}	27	80 {8.2}	65 {6.6}	55 {5.6}
75%Ar/25%CO ₂	545 {56}	587 {60}	26	98 {10.1}	78 {8.0}	68 {7.0}

Typical Undiluted Weld Metal Analysis %

C	Mn	Si	P	S
0.07	1.61	0.63	0.011	0.011

*Shielding Gas : 75%Ar/25%CO₂

Approvals

ABS, LR, DNV, BV, GL, JIS