

Coreweld Ultra

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

Flux
CORED
WIRES

Description

- Coreweld Ultra is a low fume, metal cored wire. This wire produces 40% less fume than the conventional metal cored products. The use of higher argon shielding gas further reduces fume, spatter and slag islands. The higher deposition efficiency and improved welder appeal minimizes post weld clean-up.
- Coreweld Ultra was developed for carbon steels having tensile strength up to 70 ksi (483 Mpa). This metal cored wire is intended for single or multipass welding in the flat and horizontal positions.

Shielding Gas : 100%CO₂, 75%Argon/25%CO₂ or 92%Argon/8%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	-30°C
100%CO ₂	440 {45}	531 {54}	29	51 {5.2}	39 {4.0}
75%Ar/25%CO ₂	449 {46}	545 {56}	28	58 {5.9}	42 {4.3}

Typical Undiluted Weld Metal Analysis %

Gas	C	Mn	Si	P	S
100%CO ₂	0.030	1.36	0.54	0.008	0.019
75%Ar/25%CO ₂	0.038	1.53	0.61	0.010	0.017

Approvals

ABS, LR, DNV, NK, BV, GL, KR