

Dual Shield 70 Ultra Plus

AWS A5.20 E71T-9C/9M / JIS Z3313 T493T1-1C(M)A

Flux
CORED
WIRES

Description

- Dual Shield 70 Ultra Plus is an all-position wire that is uniquely designed to provide high deposition, outstanding all position performance and a fume emission rate approaching that of solid wires. It is optimized for use with 90%Ar/10%CO₂ shielding but works well with mixes ranging from 75%Ar/25%CO₂ to 95%Ar/5%CO₂. Among the outstanding features of Dual Shield 70 Ultra Plus are a very wide operating window, very high out of position deposition rates (vertical up and overhead at over 12 lb/hr), and welds that are virtually spatter free.
- Dual Shield 70 Ultra Plus may be used in a variety of applications including railcar, automotive, heavy equipment, and general structural steel fabrication. It is especially recommended in applications where reduction of welding fume is a priority.

Shielding Gas : 100%CO₂ or Ar/CO₂ mixtures between 75-95%Ar

Typical Mechanical Properties of All Weld Metal

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	498 {50.8}	534 {54.5}	31	132 {13.5}	122 {12.4}	105 {10.7}
75%Ar/25%CO ₂	505 {51.5}	562 {57.3}	31	143 {14.6}	124 {12.6}	112 {11.4}

Typical Undiluted Weld Metal Analysis %

Gas	C	Mn	Si	P	S
100%CO ₂	0.053	1.02	0.64	0.013	0.008
75%Ar/25%CO ₂	0.051	1.11	0.72	0.013	0.009

Approvals

ABS, LR, DNV, BV, GL