

Dual Shield II 70 Ultra

AWS A5.20 E71T-1C/1M/12M / JIS Z3313 T492T1-1MA-U / EN ISO 17632-A T463 P M1 H10

Description

- Dual Shield II 70 Ultra is an all-position flux cored wire that displays exceptional impact properties in both the as welded and stress relieved conditions when used with 75%Ar/25% CO₂. The improved properties qualify this wire to the Navy's "HY" classification. The "Ultra" series produces smoother arc characteristics and lower welding fumes.

Flux
CORED
WIRES

Shielding Gas : 75%Argon/25%CO₂

Application

- Dual Shield II 70 Ultra was developed to join low and medium carbon steel. The Military classification allows Dual Shield II 70 Ultra to be used for attaching steels of less than 80 ksi(552MPa) yield to HY-80 and HY-100. Commercial applications include construction, shipbuilding, railcar, and heavy equipment industries. Weld metal analysis is similar to an E7018 low hydrogen electrode.

Typical Mechanical Properties of All Weld Metal

Yield Point N/mm ² {kgf/mm ² }	Tensile Strength N/mm ² {kgf/mm ² }	Elongation (%)	Impact Value J(kgf · m)	
			-20°C	-30°C
500 {51}	565 {58}	34	130 {13}	66 {7}

Typical Undiluted Weld Metal Analysis %

C	Mn	Si	P	S
0.05	1.05	0.41	0.010	0.010

Approvals

ABS, LR, DNV, BV, GL, NK, CCS, TUV, JIS, KR