

# Dual Shield R-70 Ultra

AWS A5.20 E70T 1C/1M/9C/9M / JIS Z3313 T493T1-0CA

## Description

- Dual Shield R-70 Ultra is a low fuming flux cored wire with a balanced chemistry that allows for a greater tolerance of mill scale and surface oxides than is normally associated with an E70T-1 class of wire. The "Ultra" series produces smoother arc characteristics and lower welding fumes than other non-ultra types. Notch toughness in the as welded condition is also improved with this wire. Bead contour is flat to slightly convex and slag coverage is complete.

Flux  
CORED  
WIRES

## Shielding Gas : 100%CO<sub>2</sub>

## Application

- Dual Shield R-70 Ultra wire is designed for single or multipass applications on low or medium carbon steels. It is intended for use in the flat and horizontal positions with CO<sub>2</sub> shielding only. Areas of application include railcar, heavy equipment, and general fabrication.

## Typical Mechanical Properties of All Weld Metal

Yield Point N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	Tensile Strength N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	Elongation (%)	Impact Value J(kgf · m)	
			-20°C	-30°C
483 {49}	555 {57}	26	74 {7.5}	60 {6.1}

## Typical Undiluted Weld Metal Analysis %

C	Mn	Si	P	S	Ni
0.040	1.36	0.51	0.011	0.012	0.39