

# Dual Shield R-70

AWS A5.20 E70T-1C/9C / JIS Z3313 T492T1-0CA-U

Flux  
CORED  
WIRES

## Description

- Dual Shield R-70 is a flux cored wire with a chemistry balance that allows for a greater tolerance of mill scale and surface oxides than is normally associated with an E70T-1 class of electrode. Notch toughness in the as welded condition is also improved with this balance. Bead contour is flat to slightly convex and slag coverage is complete.

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

## Application

- Dual Shield R-70 is a flux cored wire 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)	
			0 °C	-20 °C
480 {49}	550 {56}	28	88 {8.9}	52 {5.3}

## Typical Undiluted Weld Metal Analysis %

C	Mn	Si	P	S
0.06	1.60	0.65	0.014	0.003

## Approvals

ABS, DNV, BV, GL, NK, KR, LR, RINA, JIS, KS