

SF-70MX

AWS A5.20 / ASME SFA5.20 E70T-1C
EN ISO 17632-A-T 420 R C 3

TYPE : Semi-Metal

Applications

As a high deposition cored wire, it is designed for high production welding of structural steels in excess of 6mm.

Characteristics on Usage

This wire benefits from a high deposition rate with very low spatter loss. It gives excellent penetration and good arc stability.

Notes on Usage

- 1) Proper preheat (50~150°C) and interpass temperature must be used in order to release hydrogen which may cause cracking in weld metal when electrodes are used for medium and heavy plates.
- 2) Use 100% CO₂ gas.

Welding Position



1G (PA) 2F (PB)

Current

DC +

Shielding Gas

CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.05	0.50	1.50	0.011	0.010

Typical Mechanical Properties of All-Weld Metal

YS MPa	TS MPa	EL (%)	Temp. °C	CVN-Impact Value J
560	590	28	0	60

Approval

KR, ABS, LR, BV, DNV, GL,
NK, CCS, CCRS, RINA, CWB

Packing

Dia. (mm)	1.2	1.6	2.4	Spool (kg)	15	Coil (kg)	25

Sizes Available and Recommended Current (Amp.)

Size, mm F & HV	1.2 250~300	1.6 300~350	2.4 350~450

Diam.	15 kg Spool	25 kg Coil
1.2mm	HKSF70MX12	
1.6mm	HKSF70MX16	
2.4mm		HKSF70MX24

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