

# Supercored 70NS

AWS A5.18 / ASME SFA5.18 E70C-6M  
EN ISO 17632-A-T 42 3 M M 3 H5

TYPE: Metal-Cored

## Applications

Supercored 70NS is used for welding in shipbuilding, machinery, bridge construction, structural fabrication, automated or robotic welding.

## Characteristics on Usage

Supercored 70NS is a metal-cored wire which combines the high deposition rates of F.C.W with the high efficiencies of a solid wire, providing exceptionally smooth and stable arc, low spatter and minimal slag coverage.

## Notes on Usage

- 1) Proper preheat and interpass temp. (50~150°C) must be used in order to release hydrogen which may cause cracking in welds when the wire is used for medium and heavy plates.
- 2) Use Ar+20~25% CO<sub>2</sub> gas.

## Welding Position



1G (PA) 2F (PB) 3G (PF)

## Current

DC+

## Shielding Gas

Ar+20~25% CO<sub>2</sub>

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.05	0.55	1.45	0.013	0.010

## Typical Mechanical Properties of All-Weld Metal

YS MPa	TS MPa	EL (%)	Temp. °C	CVN-Impact Value J
480	550	27.0	-30	50

## Approval

ABS, LR, BV, DNV, GL, TÜV,  
CWB, CE, DB, RINA

## Packing

Dia. (mm) 1.2 1.6

Spool(kg) 15

## Sizes Available and Recommended Currents (Amp.)

Size, mm F & HF	1.2	1.6
	230~300	290~360

Diam.	15 kg Spool
1.2mm	HK70NS12
1.6mm	HK70NS16

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