

SC-70A

Type : Metal-Cored



Conformances

AWS A5.36/ ASME SFA5.36 E70T15-C1A0-CS1
E70T15-M21A2-CS1
(AWS A5.18 / ASME SFA5.18 E70C-3C
E70C-6M)
EN ISO 17632-A-T 42 2 M C1 1 H5
EN ISO 17632-A-T 46 2 M M21 1 H5
ABS 3YSA H5
LR 3YS H5
BV SA3Y H5
DNV IIIYS H5

RINA 3YS H5
TÜV EN ISO 17632-A - T 42 2 M C 1 H5
/ T 46 2 M M 1 H5
DB EN ISO 17632-A - T 42 2 M C 1 H5
/ T 46 2 M M 1 H5
CWB CSA W48-06 E491C-6M-H8
CE

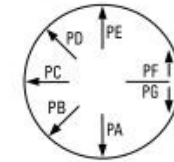
Applications

- Shipbuilding, bridge construction machinery, and vehicles.

Features

- Designed for welding with 100% CO₂ shielding gas
- Excellent weld-ability and low spatter
- Exceptionally smooth and stable arc with a fast freezing slag system

Welding Position



Current

DC +

Shielding Gas

Ar + 20-25% CO₂
100% CO₂

Typical Chemical Composition of All-Weld Metal (%)

	C	Si	Mn	P	S
100% CO ₂	0.06	0.50	1.20	0.011	0.006
80% Ar + 20% CO ₂	0.07	0.58	1.43	0.011	0.007

Typical Mechanical Properties of All-Weld Metal

	YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.-lbs)
100% CO ₂	446 (64,742)	530 (76,935)	30	-20 (-4)	50 (37)
80% Ar + 20% CO ₂	492 (71,419)	580 (84,193)	26	-30 (-22)	57 (42)

Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)	Efficiency (%)
1.2mm (0.045 in) DC+						
100% CO ₂	19-25 (3/4-1)	2.4 (90)	80	17	0.8 (1.8)	90-92
		4.8 (190)	160	23	2.8 (6.2)	91-93
		9.8 (390)	250	28	4.0 (8.8)	92-94
		12.7 (500)	300	32	5.4 (11.9)	93-95
80% Ar + 20% CO ₂	19-25 (3/4-1)	7.4 (290)	200	24	2.7 (5.9)	92-94
		9.8 (390)	250	28	4.2 (9.2)	93-95
		12.7 (500)	300	30	5.7 (12.5)	95-97

Diam.	15 kg Spool
1.2mm	HCSC70A12
1.6mm	HCSC70A16

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