

Supercored 70NS

TYPE : Metal-Cored

AWS A5.18 / ASME SFA5.18 E70C-6M
JIS Z3313 T49 3 T15-0 M A H5
EN ISO 17632-A-T 42 3 M M 3 H5

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, provides exceptionally smooth and stable arc, low spatter and minimal slag coverage.

Notes on Usage

- ① Proper preheating(50~150° C)(122~302° F) 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 One-side welding defects such as hot cracking in may occur with wrong welding parameter such as high welding speed.
- ③ Use Ar+20~25% CO₂ gas.

Welding Position



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

Current

DC +

Shielding Gas

Ar+20~25%CO₂

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(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
480 (69,700)	550 (79,900)	27.0	-30 (-22)	50 (37)

Approval

I Packing(Including Ball Pac)

ABS, LR, BV, DNV, GL, TÜV, CWB, CE, DB, RINA	Dia. (mm) (in)	1.0 .039	1.2 .045	1.4 .052	1.6 1/16	Spool(kg) (lbs)	12.5 28	15 33	20 44
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Sizes Available and Recommended Currents (Amp.)

Size mm(in) F & HF	1.2 (.045) 230~300	1.4 (.052) 260~340	1.6 (1/16) 290~360
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