

Strongweld Metal Cored Tubular Wire E70C-6M

High Tensile Steel Tubular Wire for Flux Core Arc Welding (FCAW) with gas protection.

Classification

AWS A5.18/A5.18M

E70C-6M

* Meets AWS 1.8 & FEMA 353

Description

- Strongweld Metal Cored E70C-6M (aka Indura 70C-6M) is designed for welding of 490MPa high tensile steel with only Ar/CO² mixtures. It is especially suitable for fillet welding and has a high tolerance to primer.
- Wire is a metal type of flux cored wire for flat and horizontal position welding.
- It features good penetration, high resistance to porosity, good wetting behavior as well as low hydrogen contents.
- The shielding gas that should be used for welding is Ar+20-25%CO².

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

C	Si	Mn	P	S
0.04	0.60	1.50	0.014	0.013

Typical Mechanical Properties of All-Weld Metal:

	Yield Strength, Ksi	Tensile Strength, Ksi	Elongation (L=4d), %	Impact Test Charpy-V
AWS A5.18	Min. 58	Min. 70	22 min.	20 ft*lbf at -20°F
Strongweld 70C-6M	77	88	27	40 ft*lbf at -20°F

Approvals:

ABS | BV | CWB | DNV | GL | LR | RINA | JIS | KS

(Ar+2-20%CO₂CWB)

Packaging, sizes and code SAP:

Diameter	0.045"/1.1mm		1/16"/1.6mm	
Packaging	33lb	44lb	33lb	44lb
Code SAP	1038382	1032475	1039018	1032474

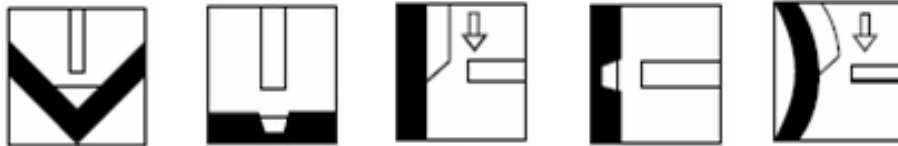
Calculation Data:

Diameter	Stick- Out (Pulg)	Wire Feed Speed (Pulg/min)	Current (A)	Arc Voltage (v)	Deposition Rate (lb/h)
0.045"	5/8	250	180	28-30	6
		370	270	31-34	10
		555	340	35-38	15

Recommender Operating Parameters:

Diameter, Inch	0.045"/1.1mm	1/16"/1.6mm
Current (amp)	160-350	240-420
Voltage, Volts	24-32	26-35
ESO, Inch	1/2 to 1"	1/2 to 1"

Welding Positions



DCEP – DC+