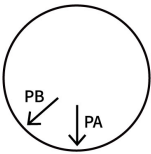


SF-70MX

Classification

AWS AWS A5.20 / ASME SFA-5.20 E70T-1C
JIS Z 3313 T49 J 0 T1-0 C A-U
EN ISO 17632-A T 42 0 R C1 3

Welding Positions



Features

- Designed for welding with 100% CO2 shielding gas
- Good high deposition rate
- Good penetration and good arc stability
- Good anti-porosity

Polarity

DC +

Application Areas

- Shipbuilding
- Structural fabrication
- General fabrication
- Transportation equipment

Shielding Gas

100% CO2

Approvals

ABS	BV	CCS	CR	DNV	KR	LR	NK	RINA	CWB	CE
✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓

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

Shielding Gas	C	Si	Mn	P	S
100% CO2	0.05	0.50	1.50	0.011	0.013

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
100% CO2	560 (81)	590 (85)	28	0 (32) -20 (0)	60 (44) 50 (37)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)	Packaging
1.2 (0.045)	110~280	Spool 5kg (11lbs), 12.5kg (28lbs), 15kg (33lbs), 20kg (44lbs) Drum 100kg (221lbs), 200kg (441lbs), 250kg (551lbs)
1.4 (0.052)	110~280	
1.6 (1/16)	120~300	

SMW

GMW

GTW

FCW

Metal-cored Wire

SAW Wire

SAW Flux