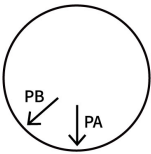


Supercored 70B

Classification

**AWS** AWS A5.20 / ASME SFA-5.20 E71T-5M-J  
**JIS** Z 3313 T49 4 T5-1 M A-U  
**EN** ISO 17632-A T42 4 B M21 3 H5

Welding Positions



Features

- Designed for welding with Ar+20~25%CO2 shielding gas
- Good crack resistance
- Good impact value at low temperature

Polarity

DC -

Application Areas

- Shipbuilding
- Structural fabrication

Shielding Gas

Ar+20~25% CO2

Approvals

|     |    |     |    |    |    |     |
|-----|----|-----|----|----|----|-----|
| ABS | BV | DNV | LR | CE | DB | TUV |
| ✓   | ✓  | ✓   | ✓  | ✓  | ✓  | ✓   |

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

|               |      |      |      |       |       |
|---------------|------|------|------|-------|-------|
| Shielding Gas | C    | Si   | Mn   | P     | S     |
| Ar+20~25% CO2 | 0.06 | 0.43 | 1.33 | 0.011 | 0.013 |

Typical Mechanical Properties of All-Weld Metal

|               |                            |                              |                   |                        |                                |
|---------------|----------------------------|------------------------------|-------------------|------------------------|--------------------------------|
| Shielding Gas | Yield Strength<br>MPa(ksi) | Tensile Strength<br>MPa(ksi) | Elongation<br>(%) | Temperature<br>°C (°F) | Impact Toughness<br>J (ft·lbs) |
| Ar+20~25% CO2 | 450 (65)                   | 520 (75)                     | 32                | -40 (-40)              | 78 (58)                        |

Diameter / Welding Parameters / Packaging

| Wire Diameter<br>mm(in) | Current<br>(A) | Packaging                                                                                                            |
|-------------------------|----------------|----------------------------------------------------------------------------------------------------------------------|
| 1.2 (0.045)             | 110~280        | Spool 5kg (11lbs), 12.5kg (28lbs), 15kg (33lbs), 20kg (44lbs)<br>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