

Description

SFA M70 is a metal cored wire which combines the high deposition rates of FCW and the high efficiencies of a solid wire. The use of higher argon shielding gas further reduces fume, spatter and slag Islands. This metal cored wire is intended for single or multi pass welding in the flat and horizontal. For mild steel and 490N/mm² class high tensile strength steel.

Notes on usage

The optimum flow of 75~85%Ar+25~15%CO₂ for shielding is 20~25ℓ/min. The distance between tip & base metal is to be 15~25mm. Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.

Applications

SFA M70 Butt, fillet welding of mild steel & 490N/mm² high tensile strength steels of structure such as ships, bridges, buildings and storage tanks etc.

Classification

AWS A5.36 E70T15-M21A2-CS1-H4 AWS A5.18 E70C-6M KS D 7104 YFW-A50DM JIS Z3313 T493T15-0MA-H5

Typical weld metal chemical composition (%) (Shielding Gas : 80%Ar+20%CO₂)

C	Mn	Si	P	S
0.05	1.60	0.75	0.018	0.015

All weld metal mechanical properties (typical) (Shielding Gas : 80%Ar+20%CO₂)

Yield Strength N/mm ² (MPa)	Tensile Strength N/mm ² (MPa)	EL %	IV (J)	
			-20°C	-30°C
490	550	28.0	85	65

Size & recommended current range (DC+)

Dia. mm (in)		1.2 (0.045)	1.4 (0.052)	1.6 (0.062)
Amp.	F & H-F	180~340	200~360	200~400