

Supercored 70MXH

Type : Semi-Metal

Conformances

AWS A5.36/ ASME SFA5.36 E70T1-C1A2-CS1
 (AWS A5.20/ ASME SFA5.20 E70T-9C)
 JIS Z3313 T49 J 2 T1-0 C A -U H5
 EN ISO 17632-A-T 42 2 R C1 H5
 KR 3YSG(C) H5, 3YMG(C) H5
 ABS 3SA H5, 3YSA
 LR 3YS H5
 BV SA3YM, A3YM HHH

DNV-GL IIIYMS H5
 NK KSW53G(C) H5
 KAW53MG(C) H5
 CCS 3YSM H5
 RINA 3YS H5

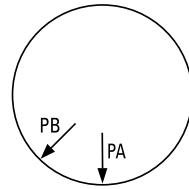
Applications

- Shipbuilding
- Structural fabrication
- General fabrication
- Heavy equipment
- Offshore structure

Features

- Designed for welding with 100% CO₂ shielding gas
- High speed single or twin tandem welding
- Low hydrogen level (H5)
- Good anti-porosity to zinc primer

Welding Position



Current

DC +

Shielding Gas

100% CO₂

Diameter / Packaging

| Diameter | Spool | | | Pac | | |
|-------------|-------------|--------------|--------------|----------------|----------------|----------------|
| | 5kg (11lbs) | 15kg (33lbs) | 20kg (44lbs) | 250kg (551lbs) | 300kg (661lbs) | 500kg (771lbs) |
| 1.4 (0.052) | | √ | √ | √ | √ | √ |
| 1.6 (1/16) | | √ | √ | √ | √ | √ |

Typical Chemical Composition of All-Weld Metal (%)

| C | Si | Mn | P | S |
|------|------|------|-------|-------|
| 0.05 | 0.55 | 1.65 | 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) |
|---------------------------------|---------------------------------|-----------|----------------|---------------------------------|
| 540 (78,400) | 620 (90,000) | 28 | -30 (-22) | 54(40) |

Typical Welding Parameters

| Diameter, Polarity Shielding Gas | CTWD mm (in) | Wire Feed Speed m/min (in/min) | Amp. (A) | Volt. (V) | Deposition Rate kg/hr (lb/hr) | Efficiency (%) |
|-------------------------------------|-----------------|-----------------------------------|-------------|--------------|----------------------------------|-------------------|
| 1.4mm (0.052 in) DC+ | | | | | | |
| 100% CO ₂ | 25 (1) | 12.2 (480) | 280~320 | 29~33 | 5.6 (12.4) | 90~92 |
| | | 13.1 (515) | 330~370 | 34~38 | 6.1 (13.4) | 91~93 |
| | | 15.0 (590) | 380~420 | 36~40 | 6.4 (14.1) | 91~93 |
| 1.6mm (1/16 in) DC+ | | | | | | |
| 100% CO ₂ | 25 (1) | 7.6 (300) | 280~320 | 31~35 | 4.9 (10.8) | 87~89 |
| | | 8.9 (350) | 330~370 | 34~38 | 5.5 (12.1) | 90~91 |
| | | 10.2 (400) | 380~420 | 36~40 | 6.3 (13.9) | 90~91 |
| | | 11.8 (500) | 430~470 | 40~44 | 7.7 (17.0) | 91~92 |

SWAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX