

# Supercored 70SB

Type : Basic

Supercored 70SB

## Conformances

AWS A5.20 / ASME SFA5.20 E71T-5C  
 JIS Z3313 T49 4 T5-1 M A-U H5  
 EN ISO 17632-A-T 423 B C 2 H5  
 KR 3YSG(C1)H5  
 ABS 3SA,3YSAH5

LR 3YSH5  
 BV SA3YM HHH  
 DNV IIIYMS H5  
 GL 3YH5S  
 NK KSW53G(C)H5

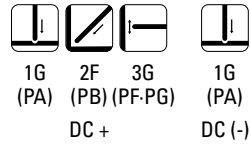
## Applications

- Shipbuilding
- Structural fabrication
- Heavy equipment

## Features

- Good crack resistance
- Good impact value at low temperature

## Welding Position



## Current

DC ±

## Shielding Gas

100% CO<sub>2</sub>

## Diameter / Packaging

Diameter mm (in)	Spool			Pac		
	12.5kg (28lbs)	15kg (33lbs)	20kg (44lbs)	250kg (551lbs)	300kg (661lbs)	350kg (771lbs)
0.8 (0.033)						
0.9 (0.035)						
1.0 (0.040)						
1.2 (0.045)	√	√	√			
1.4 (0.052)	√	√	√			
1.6 (1/16)	√	√	√			

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

C	Si	Mn	P	S
0.07	0.5	0.4	0.008	0.01

## Typical Mechanical Properties of All-Weld Metal

YS Mpa(lbs/in <sup>2</sup> )	TS Mpa(lbs/in <sup>2</sup> )	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)	Polarity
570 (82,800)	620 (90,000)	26	-30 (-22)	70 (52)	DC (-)
500 (72,600)	550 (79,900)	31	-30 (-22)	80 (59)	DC (+)

## Typical Operating Procedures

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Voltage (volts)	Approx. Current (amps)	Deposition Rate kg/hr (lb/hr)	Efficiency (%)
1.2mm (0.045 in) DC+						
100% CO <sub>2</sub>	25 (1)	4.5 (175)	18-23	120-160	1.5 (3.3)	86-88
		6.4 (250)	19-25	135-175	2.2 (4.8)	
		7.6 (300)	20-26	150-180	2.5 (5.5)	
		8.9 (350)	23-28	175-205	3.0 (6.6)	
		10.2 (400)	25-30	185-220	3.5 (7.6)	
		11.5 (450)	26-31	220-260	3.8 (8.4)	
		12.8 (500)	27-32	250-290	4.4 (9.6)	
1.4mm (0.052 in) DC+						
100% CO <sub>2</sub>	25 (1)	3.8 (150)	20-25	130-170	1.9 (4.1)	85-89
		5.1 (200)	21-26	160-200	2.5 (5.5)	
		6.4 (250)	22-28	180-230	3.0 (6.6)	
		7.6 (300)	23-29	220-260	4.2 (9.2)	
		10.2 (400)	27-32	270-320	5.5 (12.1)	
		12.8 (500)	28-34	300-350	6.0 (13.2)	
1.6mm (1/16 in) DC+						
100% CO <sub>2</sub>	25 (1)	3.2 (125)	22-25	170-210	2.0 (4.4)	84-87
		3.8 (150)	23-26	180-220	2.5 (5.5)	
		5.1 (200)	25-29	220-260	3.2 (7.0)	
		6.4 (250)	26-32	270-320	4.0 (8.8)	
		7.6 (300)	28-34	300-350	5.0 (11.0)	
		10.2 (400)	34-38	350-400	6.4 (14.0)	