

SC-70Z Cored

Type : Metal-Cored

Conformances

AWS A5.36M/ ASME SFA5.36M E490T15-C1A0-G
E490T15-M21A0-G

(AWS A5.18/ ASME SFA5.18 E70C-G)

EN ISO 17632-A-T 46 Z M C1 3

EN ISO 17632-A-T 46 Z M M21 3

CWB CSA W48 E491T-G

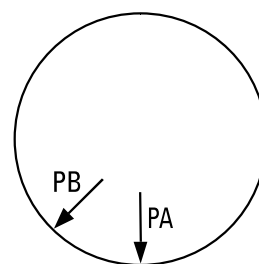
Applications

- Automotive
- Galvanized steel structure
- Shipbuilding

Features

- Designed for low carbon and low alloy galvanized steel sheet
- Applicable to the zinc plate steel
- Low spatter
- Good anti-porosity

Welding Position



Current

DC +

Shielding Gas

100% CO₂

Ar + 20~25% CO₂

Diameter / Packaging

Diameter	Spool			Pac		
	5kg (11lbs)	15kg (33 lbs)	20kg (44lbs)	250kg (551lbs)	300kg (661lbs)	350kg (771lbs)
mm (in)						
1.0 (0.040)	√	√	√	√	√	√
1.2 (0.045)	√	√	√	√	√	√

Typical Chemical Composition of All-Weld Metal (%)

	C	Si	Mn	P	S
100% CO ₂	0.09	0.42	1.35	0.022	0.013
80% Ar + 20% CO ₂	0.10	0.61	1.57	0.025	0.014

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)
100% CO ₂	550 (68,600)	600 (79,900)	30	0 (32)	120 (89)
80% Ar + 20% CO ₂	580 (80,100)	640 (86,800)	25	0 (32)	105 (77)

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 (%)
1.2mm (0.045 in) DC+						
100% CO ₂	19-25 (3/4-1)	Flat & Horizontal				
		4.8 (190)	160	21	2.7 (5.9)	91-93
		9.8 (390)	250	30	4.3 (9.5)	92-94
		12.7 (500)	300	32	5.2 (11.4)	93-95
80% Ar + 20% CO ₂	19-25 (3/4-1)	Flat & Horizontal				
		6.1 (240)	180	21	2.8 (6.2)	91-93
		9.8 (390)	250	28	4.4 (9.7)	93-95
		12.7 (500)	300	31	5.4 (11.9)	96-98