

# SF-70W

Type : Rutile

## Conformances

AWS A5.36/ ASME SFA5.36 E71T1-C1A0-G(W)

JIS Z3320 YFA-50W

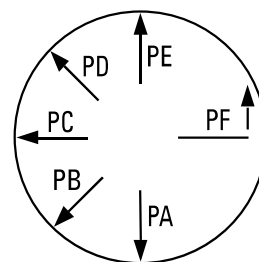
## Applications

- Bridge construction
- Civil construction

## Features

- Good weather proof

## Welding Position



## Current

DC +

## Shielding Gas

100% CO<sub>2</sub>

## Diameter / Packaging

Diameter	Spool			Pac		
	12.5kg (28lbs)	15kg (33lbs)	20kg (44lbs)	100kg (221lbs)	200kg (441lbs)	250kg (551lbs)
mm (in)						
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	Cr	Ni	Cu
0.04	0.45	1.05	0.017	0.011	0.5	0.35	0.4

### 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)
510 (74,000)	580 (84,200)	28	-20 (4)	46 (34)

### 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 (%)
<b>1.2mm (0.045 in) DC+</b>						
100% CO <sub>2</sub>	25 (1)	4.5 (175)	120~160	18~23	1.6 (3.5)	86~88
		6.4 (250)	135~175	19~25	2.3 (5.1)	
		7.6 (300)	150~180	20~26	2.6 (5.7)	
		8.9 (350)	175~205	23~28	3.1 (6.8)	
		10.2 (400)	185~220	25~30	3.6 (7.9)	
		11.5 (450)	220~260	26~31	3.9 (8.6)	
		12.8 (500)	250~290	27~32	4.5 (9.8)	
15.3 (600)	280~320	28~33	5.3 (11.6)			
<b>1.4mm (0.052 in) DC+</b>						
100% CO <sub>2</sub>	25 (1)	3.8 (150)	130~170	20~25	2.0 (4.3)	86~88
		5.1 (200)	160~200	21~26	2.5 (5.5)	
		6.4 (250)	180~230	22~28	3.0 (6.6)	
		7.6 (300)	220~260	23~29	4.2 (9.2)	
		10.2 (400)	270~320	27~32	5.6 (12.3)	
		12.8 (500)	300~350	28~34	6.1 (13.4)	
<b>1.6mm (1/16 in) DC+</b>						
100% CO <sub>2</sub>	25 (1)	3.2 (125)	170~210	22~25	2.1 (4.6)	85~87
		3.8 (150)	180~220	23~26	2.6 (5.7)	
		5.1 (200)	220~260	25~29	3.2 (7.0)	
		6.4 (250)	270~320	26~32	4.0 (8.8)	
		7.6 (300)	300~350	28~34	5.1 (11.2)	
		10.2 (400)	350~400	34~38	6.5 (14.2)	

SMAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX