

# Supershield 7

Type : Self-Shielded

## Conformances

AWS A5.36/ ASME SFA5.36 E70T7-AZ-CS3  
(AWS A5.20/ ASME SFA5.20 E70T-7)  
EN ISO 17632-A-T 46 Z Z W NO 3

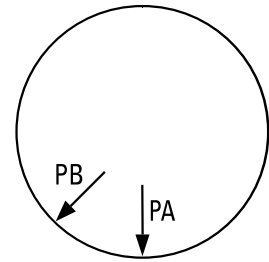
## Applications

- general fabrication
- Heavy equipment
- Machinery

## Features

- High deposition rate
- Easy slag removal
- Good crack resistance
- Good porosity resistance

## Welding Position



## Current

DC -

## Shielding Gas

No shielding gas

## Diameter / Packaging

Diameter	Spool	Coil
mm (in)	12.5kg (28lbs)	25kg (55lbs)
2.0 (0.078 in)	✓	✓
2.4 (0.094 in)		✓

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

C	Si	Mn	P	S	Al
0.26	0.17	0.25	0.011	0.005	1.54

## Typical Mechanical Properties of All-Weld Metal

YS Mpa(lbs/in <sup>2</sup> )	TS Mpa(lbs/in <sup>2</sup> )	EL (%)
492 (71,400)	635 (92,100)	23

## 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>2.0mm (0.078 in) DC-</b>						
No shielding gas	40 (1.57)	3.9 (155)	250~280	23~27	3.5 (7.7)	78~82
		5.0 (200)	290~320	24~28	4.3 (9.4)	
		6.2 (245)	330~360	24~29	5.3 (11.6)	
<b>2.4mm (0.094 in) DC-</b>						
No shielding gas	45 (1.77)	3.3 (130)	270~300	23~26	4.4 (9.7)	79~84
		4.0 (160)	310~340	24~27	5.6 (12.3)	
		4.6 (185)	350~380	24~28	6.6 (14.5)	
		5.4 (215)	390~420	25~30	7.4 (16.3)	

SMAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX