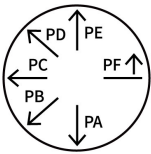


SC-70ML

Classification

**AWS** AWS A5.18/ ASME SFA-5.18 E70C-6M  
**JIS** Z 3313 T49 4 T15-1 M A-U  
**EN** ISO 17632-A T46 4 M M21 2 H5

Welding Positions



Features

- Designed for welding with Ar+CO2 mixed gas
- High deposition rates & minimal slag coverage
- Good impact value at low temperature
- Meets AWS D1.8 seismic requirements

Polarity

DC+

Application Areas

- Structural fabrication
- Steel industry
- Heavy equipment & machinery
- Shipbuilding

Shielding Gas

Ar+20~25% CO2

Approvals

|     |    |     |    |      |     |    |    |     |
|-----|----|-----|----|------|-----|----|----|-----|
| ABS | BV | DNV | LR | RINA | CWB | CE | DB | TUV |
| ✓   | ✓  | ✓   | ✓  | ✓    | ✓   | ✓  | ✓  | ✓   |

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

|               |      |      |      |       |       |      |
|---------------|------|------|------|-------|-------|------|
| Shielding Gas | C    | Si   | Mn   | P     | S     | Ni   |
| Ar+20~25% CO2 | 0.04 | 0.56 | 1.57 | 0.010 | 0.010 | 0.34 |

Typical Mechanical Properties of All-Weld Metal

|               |                            |                              |                   |                        |                                |
|---------------|----------------------------|------------------------------|-------------------|------------------------|--------------------------------|
| Shielding Gas | Yield Strength<br>MPa(ksi) | Tensile Strength<br>MPa(ksi) | Elongation<br>(%) | Temperature<br>°C (°F) | Impact Toughness<br>J (ft·lbs) |
| Ar+20~25% CO2 | 476 (69)                   | 553 (80)                     | 26.5              | -30 (-20)<br>-40 (-40) | 86 (63)<br>75 (55)             |

Diameter / Welding Parameters / Packaging

|                         |                |
|-------------------------|----------------|
| Wire Diameter<br>mm(in) | Current<br>(A) |
| 1.2 (0.045)             | 140~300        |

SMW

GMW

GTW

FCW

Metal-cored Wire

SAW Wire

SAW Flux