

SC-70ML

TYPE : Metal-Cored

AWS A5.18/ ASME SFA5.18 E70C-6M
JIS Z3313 T49 4 T15-1 M A-U H5
EN ISO 17632-A-T 46 4 M M 2 H5

Applications

SC-70ML can be used on mild and high tensile steels in single and multi-pass applications. It is ideally suited for high production and automatic applications. Typical industrial applications include offshore, heavy equipment and general structural fabrications.

Characteristics on Usage

SC - 70ML is a gas shielded metal-cored wire which combines high deposition rates of a flux cored wire with high efficiency of a solid wire. Its design achieves low temperature impacts and can be used in semiautomatic and automatic applications.

Notes on Usage

① Use Ar + 20 ~ 25% CO₂ gas.

Welding Position



1G (PA) 2F (PB) 3G (PF) 4G (PE)

Current

DC +

Shielding Gas

Ar+20~25%CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni
0.05	0.57	1.56	0.013	0.010	0.42

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)
510 (73,950)	560 (81,200)	27.0	-40 (-40)	70 (52)

Approval

ABS, LR, DNV, BV, GL
TÜV, DB, CE, CWB

I Packing

Dia. (mm) 1.2 1.4 1.6
(in) .045 .052 1/16

Spool(kg) 15
(lbs) 33

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.2 (.045)	1.4 (.052)	1.6 (1/16)
F & HF	200 ~ 300	260 ~ 340	300 ~ 350
V-up, OH	100 ~ 150	140 ~ 180	150 ~ 180