TM-70

AWS A5.18 E70C-3M/6M
EN ISO 17632-A-T 42 2 M M21 3 H5
JIS Z 3313 T 49 0 T15-0 M A

Characteristics and Applications:

TM-70 is a metallic flux cored wire designed to be used with Ar/CO_2 for mild steel and 490N/mm^2 high tensile steel, its deposition rate is 10-30% higher than a solid wire.

Multi-layer welding can be performed without removing slag. Smooth arc characteristics low diffusible hydrogen weld deposit low smoke and spatter levels. It is suitable for steel structure, bridges, shipbuilding, vehicles, storage tanks, etc.

Notes on usage:

1. Use DC(+) polarity.
2. When you use larger diameters (1.6mm or higher), we recommend higher power supply of welder.
3. Trailer Shield is essential to ensure that the weld pool is completely shielded by 75~80%Ar-25~20% CO_2 gas until solidification is complete and no porosity problem.
4. Inter-pass temperature should be under 150℃ while in multiple-pass welding.
5. Keep the product dry, while it is stored or delivered.

Typical chemical composition of weld metal (wt%):

C	Mn	Si	P	S
0.05	1.45	0.47	0.012	0.008

Typical mechanical properties of weld metal:

Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J(ft-lbf)	
			-20°C (0°F)	-30°C (-20°F)
488(71)	559(81)	31	70(52)	58(43)

Welding position:

Sizes and recommended current range (DC<+>):
Stick out: 15-25 (mm), flow rate: 20-25 (l/min)

Diameter (mm) / Parameters	1.2	1.6
F, H	240A-320A/26V-34V	270A-360A/28V-36V

FLUX CORED WIRES