70T-1 Carbon Steel Flux-Cored Wire

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com

Quality Management System
in accordance with
ISO 9001:2000
Cert # 05-R0925

American Welding Society
Sustaining Company Member

ALLOY DESCRIPTION AND APPLICATION;

70T-1 is a flux cored wire designed for single or multi pass welding having a spray-type transfer, low spatter loss, flat to slightly convex bead contour, with a moderate volume of slag completely covering the weld bead. With its high deposition rate and easily removal slag it is a good choice for mild steel as well as low alloy steels.

TYPICAL FCAW WELDING PROCEDURES; DCEP **OPTIMUM IN BOLD (FLAT)**

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stickout
0.052	150-**400**-600	140-**275**-390	19-**28**-35	1/2-1”
1/16”	150-**330**-490	150-**330**-475	23-**30**-38	1/2-1”
5/64”	120-**250**-300	250-**385**-450	26-**29**-32	3/4-1 1/4"
3/32”	110-**185**-275	300-**425**-550	25-**29**-34	3/4-1 1/4"
1/8”	70-**110**-200	380-**525**-775	27-**30**-37	3/4-1 1/4"

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

TYPICAL WELD METAL CHEMISTRY (%) AND WELD METAL PROPERTIES;

	AWS Spec.	U.S. ALLOY 70T-1 BASED ON 100% CO_2			
				AWS Spec	Typical
Carbon	0.12 max	0.03			
Manganese	1.75 max	1.45	Tensile Strength (psi)	70-95,000	82,500
Silicon	0.90 max	0.50	Yield Strength (psi)	58,000 min.	78,000
Phosphorus	0.030 max.	0.014	Elongation in 2”	22 % min.	25%
Sulfur	0.030 max.	0.013	Charpy V-notch at 0°F	20 ft·lbs min.	37 ft·lbs

AVAILABLE SIZES: TCF 70T-1= Spools of 1/16, 5/64, 3/32, 1/8

SPECIFICATIONS; ANSI/AWS A5.20 E70T-1
ASME SFA A5.20 E70T-1

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