

Applications

Butt and fillet welding of vehicles, buildings, ships, machinery, etc.

Characteristics on Usage

SM-70S is a solid wire designed for all position welding and high speed welding of steel sheets can be performed easily by short-circuiting welding.

Arc is stable and spatter loss is low.

Notes on Usage

- ① Use with CO₂/Argon+15~25% CO₂ gas.
- ② Flow quantity of shielding gas should be 25ℓ /min. approximately.
- ③ Use wind screen against wind.
- ④ Keep the distance between tip and base metal of 6~15mm for less than 250A, and 15~25mm for more than 250A of welding current.

Welding Position



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

Current

DC +

Shielding Gas

CO₂/Ar+CO₂

Typical Chemical Composition of Wire (%)

C	Si	Mn	P	S
0.07	0.65	1.14	0.015	0.010

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)
440 (63,900)	560 (81,300)	28	-20 (-4)	80 (59)

Approval

ABS, LR

I Packing (Including Ball Pac)

Dia. (mm)	0.9	1.2	1.4	1.6	Spool(kg)	15	20
(in)	.035	.045	.052	1/16	(lbs)	33	44
Ball Pac							

Sizes Available and Recommended Currents (Amp.)

Size mm(in)	0.9 (.035)	1.2 (.045)	1.6 (1/16)
F & HF	50~200	80~350	170~390
V-up,OH	50~140	50~160	-