

CSM-70C

For mild steel and 490N/mm² class high tensile strength steel

AWS	A5.18	E70C-6M
KS	D 7104	YFW-A50DM
JIS	Z3313	T493T15-0MA-H5

Applications

Butt, fillet welding of mild steel & 490N/mm² high tensile strength steels of structure such as ships, bridges, buildings and storage tanks etc.

Characteristics

- (1) CSM-70C is a Metal cored wire which combines the high deposition rates of FCW and the high efficiencies of a solid wire.
- (2) The use of higher argon shielding gas further reduces fume, spatter and slag Islands.
- (3) This metal cored wire is intended for single or multi pass welding in the flat and horizontal.

Notes on usage

- (1) The optimum flow of 75~85%Ar+25~15%CO₂ for shielding is 20~25ℓ/min.
- (2) The distance between tip & base metal is to be 15~25mm.
- (3) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.

Typical chemical composition of weld metal (%) (Shielding gas : 80%Ar+20%CO₂)

C	Mn	Si	P	S
0.05	1.60	0.75	0.018	0.015

Typical mechanical properties of weld metal (Shielding gas : 80%Ar+20%CO₂)

YP N/mm ² (MPa)	TS N/mm ² (MPa)	EL %	IV (J)	
			-20℃	-30℃
490	550	28.0	85	65

Size & recommended current range (DC +)

Dia. mm (in)		1.2 (0.045)	1.4 (0.052)	1.6 (0.062)
Amp.	F & H-F	180~340	200~360	200~400