

## Mild steel rutile cored wire

### Classification

AWS A5.20/A5.20M :E70T-1 H4/E70T-1M-H4  
 EN 758 :T 46 0 R C 3 H5/T 46 0 R M 3 H5

### General description

Gas shielded flux cored wire for semi-automatic or mechanized downhand welds  
 Low spatter, good slag removal, smooth appearance, excellent operator appeal  
 High deposition rate and deep penetration, good resistance to scale and rust  
 Reliable weld metal properties  
 Low hydrogen content  $H_{DM} < 5\text{ml}/100\text{g}$   
 Excellent wire feeding  
 Superior product consistency with optimal alloy control  
 New formulation results in 50% less fume emission

### Welding positions



ISO/ASME PA/1G PB/2F PC/2G

### Current type

DC +  
 100% CO<sub>2</sub> (EN 439:C1)  
 Ar+(>5-25%) CO<sub>2</sub> (EN 439:M21)  
 15-25 l/min

### Approvals

Shielding gases	DB
M21	+
C1	+

### Typical chemical composition of all weld metal, (w%)

Shielding gases	C	Mn	Si	P	S	$H_{DM}$ ml/100g
C1	0.06	1.30	0.50	0.015	0.010	<5
M21	0.06	1.70	0.35	0.015	0.010	<5

### Mechanical properties of all weld metal

	Shielding gas	Condition	Yield strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact (ISO), J		
						-0°C	-18°C	-30°C
Required	AWS A5.20		min.400	min.480	min. 22	min. 27		
	EN 758		min.460	530-680	min. 20	min.47		
Typical values		C1 AW	480	560	26	80		
after welding		M21 AW	530	610	27	70		

### Packaging, available sizes and identification

Unit type	Net weight/unit (kg)	Diameter (mm)
		2.4
Wire reel B435	25	X
Wooden reel	200	X

Identification Imprint: Revicod®70T-1

Revicod®70T-1: rev. EN 20

## Materials to be welded

Steel	Code	Type
General structural steel	EN 10025	S 185, S235, S275, S355
Ship plates	ASTM 131	Grade A,B,D, AH32 to DH36
Cast steel	EN 10213-2	GP240R
Pipe material	EN 10208-1	L210, L240, L290, L360
	EN 10208-2	L240NB, L290NB, L360NB, L360QB, L240MB L290MB, L360MB, L415MB, L415NB
	API 5LX	X42, X46, X52, X60
	EN 10216-1/ EN 10217-1	P235T1, P235T2, P275T1 P275T2, P355N
	EN 10028-2	P235GH, P265GH, P295GH, P355GH
Boiler & pressure vessel steel	EN 10113-2	S275, S275, S355, S420
Fine grained steel	EN 10113-3	S275M, S275ML S355M, S355ML, S420M, S420ML

## Calculation data

Diameter mm	Electrode Stick- out (mm)	Wire feed speed (cm/mm)	Current (A)	Arc Voltage (B)	Deposition Rate (kg/h)	kg Wire/kg weld metal
2.4	28	320	340	24-27	4.5	1.15
		510	450	28-31	7.3	1.15
		635	510	30-32	9.1	1.15
		700	535	31-34	10.0	1.15
		825	585	33-35	11.8	1.15

## Welding parameters, optimum fill

Diameter (mm)	Current (A)	Welding position	
	Voltage	PA/1G	PB/2F
2.4	(A)	410-560	410-510
	(V)	27-34	28-32