Revicod® 70T-1M

Mild steel rutile cored wire

Classification

AWS A5.20/A5.20M	:E70T-1- JH4/E70T-1M-JH4
EN 758	:T 46 3 R C 1 H5/T 46 3 R M 1 H5

General description

Gas shielded flux cored wire for high quality welding in downhand position
Excellent operator appeal due to superior welding characteristics
Capability with high deposition rate
Exceptional mechanical properties (CVN > 47J at -30°C)
Low hydrogen H_{DM} < 5 ml/100g
Superior product consistency with optimal alloy control
Excellent wire feeding
Very suitable for welding of root runs on ceramic backing and welding on primed plate

Welding positions

ISO/ASME PA/1G PB/2F

Current type

DC +
100% CO_2 (EN 439:C1)
Ar+(>5-25%) CO_2 (EN 439:M21)
15-25 l/min

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

Shielding gases	C	Mn	Si	P	S	H_{DM} ml/100g
C1 /M21	0.04	1.45	0.6	0.015	0.010	3

Mechanical properties of all weld metal

		Shielding gas	Condition	Yield strength (N/mm^2)	Tensile strength (N/mm^2)	Elongation (%)	Impact (ISO), J	
							-30°C	-40°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 after welding		C1 /M21	AW	570	620	25	55	40

Packaging, available sizes and identification

Unit type	Net weight/unit (kg)	Diameter (mm) 1.6
Wire reel B300	15	X
WUTPACK®Profi	200	X

Identification Imprint: Revicod®70T-1M

Revicod®70T-1M: rev. EN 20

Materials to be welded

Steel	Code	Type
General structural steel	EN 10025	S185, S235, S275, S355
Ship plates	ASTM 131	Grade A, B, D, AH32 to EH36
Cast steel	EN 10213-2	G P 240R
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/	P235T1, P235T2, P275T1
	EN 10217-1	P275T2, P355N
Boiler & pressure vessel steel	EN 10028-2	P235GH, P265GH, P295GH, P355GH
Fine grained steel	EN 10113-2	S275, S275, S355, S420
	EN 10113-3	S275M, S275ML, S355M, S355ML, S420M, S420ML

Calculation data

Diameter mm	Electrode Stick-out (mm)	Wire feed speed (cm/min)	Current (A)	Arc Voltage (B)	Deposition Rate (kg/h)	kg Wire/kg weld metal
1.6	20	320	170	21-23	1.9	1.20
		510	235	22-25	3.1	1.20
		635	275	24-26	3.9	1.20
		760	310	25-27	4.7	1.20
		890	350	27-29	5.5	1.20
		1015	385	28-30	6.3	1.20
		1080	400	29-31	6.7	1.20

Welding parameters, optimum fill, Shielding gases Ar+ (>5-25)%CO_2

Diameter (mm)	Current (A) Voltage	Welding position PA/1G	PB/2F	PC/2G	PF/3Gup	PG/3Gdown	PE/4G
1.6	(A)	250-350	250-350	230-280	220-260	170-240	170-240
	(V)	24-32	24-32	24-30	22-28	22-28	22-28