Revicod® 70T-9C

Mild steel rutile cored wire

Classification

AWS A5.20/A5.20M	:E70T-9C- H8/E70T-9M-H8
EN 758	:T 46 0 R C 3 H10/T 46 0 R M 3 H10

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} < 8ml/100g)
Excellent wire feeding
Superior product consistency with optimal alloy control

Welding positions

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

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	0.06	1.30	0.50	0.015	0.010	<8
M21	0.06	1.70	0.35	0.015	0.010	<8

Mechanical properties of all weld metal

		Shielding gas	Condition	Yield strength (N/mm²)	Tensile strength (N/mm²)	Elongation (%)	Impact (ISO), J -0°C	-29°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		40
after welding		M21	AW	530	610	27	70		40

Packaging, available sizes and identification

Unit type	Net weight/unit (kg)	Diameter (mm) 1.6	2.4
Wire reel B300	15	X	
Wire reel B435	25		x

Identification Imprint: Revicod®70T-9C

Revicod®70T-9C: 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	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/mm)	Current (A)	Arc Voltage (B)	Deposition Rate (kg/h)	kg Wire/kg weld metal
1.6	20	320	170	23-25	2.1	1.15
		510	235	25-27	3.4	1.15
		635	275	25-28	4.2	1.15
		760	310	27-29	5.0	1.15
		955	365	29-31	6.4	1.15
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, Shielding gases Ar+ (>5-25)%CO_2

Diameter (mm)	Current / Voltage	Welding position		
		PA/1G	PB/2F	PC/2G
1.6	(A)	290-380	210-375	290-340
	(V)	25-34	25-32	25-32
2.4	(A)	410-560	410-510	
	(V)	27-34	28-32	