

Applications

Butt and fillet welding of steel structures such as vehicles, machinery and bridges.

Characteristics on Usage

SM-70EN is a solid wire designed for used Ar+CO₂ mixed gas. Its property is similar to SM-70 and better than bead appearance, lower spatter for SM-70.

Notes on Usage

- ① Use with CO₂ /Argon+15~25% CO₂ gas.
- ② The Flow of quantity of shielding gas should be approximately 25ℓ /min.
- ③ Use wind screen against wind.
- ④ Keep distance between tip and base metal 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
0.08	0.95	1.70	0.019	0.015

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)
461 (66,900)	560 (81,200)	29	-29 (-20)	95 (55)

Approval

TÜV, DB, CE, DNV, GL

I Packing (Including Ball Pac)

Dia. (mm) (in)	0.9 .035	1.2 .045	1.4 .052	1.6 1/16	Spool(kg)				
					5	15	20		
					(lbs)	11	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	50~220	100~320	170~390
V-up,OH	50~140	50~140	-