

Need Metal? We get it!

SpecMet CSM-70T

AWS A5.20 E70T-1C - A5.36 E70T1-C1A0-CS1
KS D 7104 YFW-C50DM
JIS Z 3313 T49J 0 T15-0 C A-U
EN ISO 17632-A T42 0 R C[M] 3 H10 - ISO 17632-B T49 2 T15-0 C A-H10

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-70T is a metal type flux cored wire for flat & horizontal position welding with CO₂ gas shielding.
- (2) It's deposition rate is 10~30% higher compared with a solid wire, so total cost is saved.
- (3) It provides excellent usability with stable arc, less spattering better bead appearance and less quantity of welding fume comparable to solid wire.

Notes on Usage

- (1) The optimum flow of CO₂ for shielding is 20~25l/min.
- (2) The distance between tip & base metal is to be 20~25mm.
- (3) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.
- (4) Thick heavy plate should be welded under proper preheating & interpass temperature.

Typical chemical composition of weld metal (%) (shielding gas: 100% CO₂)

C	Mn	Si	P	S
0.05	1.45	0.65	0.012	0.013

Typical mechanical properties of weld metal (%) (shielding gas: 100% CO₂)

YP N/mm ² (MPa)	TS N/mm ² (MPa)	EL (%)	IV (J)	
			0°C	-20°C
540	611	27	82	50

Size and recommended current range (DC+)

Dia. Mm(in)		1.2 (0.045)	1.4 (0.052)	1.6 (1/16)
Flat H-Fillet	Amp	180~340	200~360	200~400

Approvals: CO₂ : ABS, BV, DNV, GL, KR, LR, NK