

Applications

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

Characteristics on Usage

SM-70 is a solid wire designed for all position welding by short-circuiting type transfer. As the deposition efficiency is high and penetration is deep, highly efficient welding can be performed.

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
0.07	0.83	1.48	0.017	0.020

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)
430 (62,400)	540 (78,400)	28	-29 (-20)	70 (52)

Approval

KR, ABS, LR, BV, DNV, GL,
 NK, CWB, TÜV, NAKS, MRS,
 CE, DB

I Packing (Including Ball Pac)

Dia. (mm)	0.9	1.2	1.4	1.6	Spool(kg)	5	15	20
(in)	.035	.045	.052	1/16	(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	-