

CSF-70T5

For mild steel and 490N/mm² class
high tensile strength steel

AWS A5.20 E70T-5M-J
KS D 7104 YFW-A502B
JIS Z3313 T494T5-0MA-U H5

Applications

Butt, fillet welding of 490N/mm² high tensile strength steels of structure such as ships, iron structure, buildings etc.

Characteristics

- (1) CSF-70T5 is Basic Slag type.
- (2) Low temperature impact value and crack-resistance is superior by product that is alternated in arc electrode's 7018 precincts.

Notes on usage

- (1) The optimum flow rate of Mix gas for shielding is 20~25ℓ/min.
- (2) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.
- (3) Keep the distance between tip & base metal at 15~25mm.

Typical chemical composition of weld metal (%)

(Shielding gas : 80%Ar+20%CO₂)

C	Mn	Si	P	S
0.05	1.40	0.65	0.015	0.010

Typical mechanical properties of weld metal

(Shielding gas : 80%Ar+20%CO₂)

YP N/mm ² (MPa)	TS N/mm ² (MPa)	EL %	IV (J)		Heat Treatment
			-20℃	-40℃	
460	540	30.0	125	90	As Weld
455	542	30.0	220	140	620℃×2hr

Size & recommended current range (DC +)

Dia. mm (in)		1.2 (0.045)	1.4 (0.052)	1.6 (0.062)
Amp.	F & H-F	180~320	200~340	200~360
	V-up	120~180	120~180	120~180