

CSM-70T

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

AWS	A5.20	E70T-1C
KS	D 7104	YFW-C50DM
JIS	Z3313	T49J0T15-0CA-U

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 fillet welding with CO₂ gas shielding.
- (2) Its 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 15~25mm.
- (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	27.0	82	50

Size & recommended current range (DC +)

Dia. mm (in)		1.2 (0.045)	1.4 (0.052)	1.6 (0.062)
Amp.	F & H-F	180~340	200~360	200~400

• Approval : ABS, BV, DNV, GL, KR, LR, NK