Dual Core 70 M

Metal **CORED/MCAW**

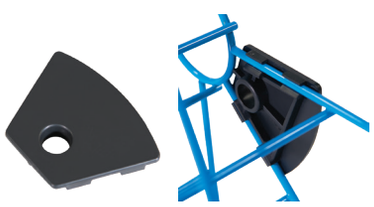
Standards

EN/ISO-Standard - 17632-A
EN/ISO-Classification - T 46 (42) 6 (2) M M21 (C1) 1 (3) H5

AWS-Standard - A5.18
AWS-Classification - E70C-6M H4

Features and Applications

- Seamless metal cored wire with remarkable stable arc and no spatter.
- Meets NACE (HIC & SSC) requirements for sour service welding application in oil & gas industry.
- Can also be used for constructions that needs post weld heat treatment after welding and still offers mechanical properties to grade 5Y46 class.
- Ideal for automated welding applications such as orbital Mag or robotic welding.
- Due to the seamless technology the typical diffusible hydrogen content is <3.0 ml 100 g.
- Test certificates supplied as 3.1 which is actual weld chemistry + mechanicals according EN 10204:2004.
- Precision layer wound for superior wire feeding characteristics.
- Typically used on steel structures, pipelines, shipbuilding, non-alloy and fine grain steels, pressure vessels, offshore, mechanical engineering, heavy transport and general fabrication etc.
- **Test Certificates can be found online @wilkinsonstar247.com**



Optional
Plastic Alignment Hole Clip
Order Code: BS300-CLIP

Typical Base Materials

Steel type	*EN*
Shipbuilding steels	A, B, D, AH 32 - EH 36
Unalloyed structural steels	S185 - S355, A 106 Gr.B, A 333 Gr. 6
Boiler steels	P235GH - P355GH
Pipe steels	P235T1/T2 - P460NL2; L210 - L445MB
Fine grain steels	S235 - S460QL1
Steel acc. API-standard	X42 - X60

* Illustrative, not exhaustive list

Welding Positions

EN ISO 6947 - PA, PB, PC, PD, PE, PF, PG

Shielding Gases

EN ISO 14175 - C1, M21

Polarity

DC (+)

Welding Parameters

Ø mm	1.20
Current (A)	90-280
Voltage (V)	14-31

Mechanical Properties

Tensile Strength (N/mm^2)	Yield Strength (N/mm^2)	Elongation (%)	Impact Strength (J)	Test Temperature
600	530	27	140	-40ºC
			100	-60ºC

Mechanical properties are approximate and may vary based on the heat, shielding gas, welding parameters and other factors.

Chemical Composition % (Typical)

C %	Si %	Mn %	P %	S %	Cr %	Ni %	Mo %	Cu %[a]	Al %	V %	Ti %	Nb %
0.06	0.75	1.56	0.008	0.006	0.022	0.021	0.005	0.085	0.006	0.005	0.015	0.002

a (Includes copper coating)

Packaging Data

Part No.	Diameter Ø (mm)	Package Weight (Kg)	Package Type	Pallet Quantity
6011100556	1.20	16	BS300 PLW	64

Drums also available.