

BW-70C

Metal Cored Welding Wire

For mild steel & 490N/mm² class high tensile steel.


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Specification: AWS A5.18:E70C-6M

Applications & Features:

BW-70C is used for butt & fillet welding of mild steel & 490N/mm² high tensile strength steels of such as ships, bridges, buildings and storage tanks etc.

Characteristics:

BW-70C is a metal cored wire which combines the high deposition rates of FCAW and high efficiencies of a solid wire.

The use of higher argon shielding gas further reduces fume, spatter and slag islands.

This wire can be used for single pass or multi pass welding in the flat and horizontal.

Notes on Usage:

The optimum flow of 75/85% Ar+25/15% CO₂ for shielding is 20-25lpm

The distance between tip & base metal is to be 20-25mm

Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec or more.

Approvals:

ABS, DNV

Part Numbers:

P/N: 2091 (1.2mm 15kg Spool)

P/N: 2091P (1.2mm 200kg Pail Pack)

P/N: 2092 (1.6mm 15kg Spool)

P/N: 2092P (1.6mm 200kg Pail Pack)



Typical chemical composition of weld metal (%)

C	Mn	Si	P	S
0.05	1.60	0.75	0.018	0.015

Typical mechanical properties of weld metal

YP N/mm ² (MPa)	TS N/mm ² (MPa)	EL %	IV (J)	
			-20°C	-30°C
490	550	28.0	85	65

Size & recommended current range (DC +)

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