

# SL-70C

## Seamless Metal Cored Wire

Betaweld SL-70C is a seamless copper coated metal cored wire with outstanding welding properties in the short-arc and spray-arc ranges depositing slag free weld metal. Almost spatter-free when welding in the spray-arc range. Good restriking, even with a cold wire tip, thus being suitable for robotic applications. Characteristic features: good side wall fusion, smooth and finely rippled welds without undercut into the base metal. Little formation of silicates on top of weld, so that multi-pass welds can be made without inter-run cleaning. Due to an easily controllable weld pool in the short-arc range, Betaweld SL-70C is well-suited for root, flat and downhand welding.

Conformance	
AS/NZS ISO	17632-B: T554T15-1MA-UH5
EN ISO	17632-A: T 46 4 M M 1 H5
EN ISO	17632-B: T554T15-1MA-UH5
AWS	A5.18: E70C-6M H4
AWS	A5.36: E71T15-M21A4-CS1-H4

Approvals	Grade
ABS	4YSA H5
BV	SA3Y M H5 KV40
DB	•
DNV	IVY40MS H5
GL	4YH5S
LRS	4Y40S H5
TUV	•



### Chemical analysis (typical values in %)

C	Mn	Si	P	S
0.08	1.5	0.4	0.010	0.010

### Shielding Gas - EN ISO 14175: M21

### Materials

S(P)235-S(P)460, GP240-GP280

### Storage

Keep dry and avoid condensation

**CE** Manufactured in Europe

### Current condition and welding position

DC+

PA PB

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J) -40 °C
580°C × 2 h/furnace	≥ 460	550-680	≥ 24	≥ 80
As Welded	≥ 460	550-680	≥ 24	≥ 60

Gas test: 82% Ar+18% CO<sub>2</sub>

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### SL-70C Operating Data

Wire Dia (mm)	Parameters	Parameters
1.2mm	90-330A	14-31V
1.6mm	180-420A	25-38V

This operating data is given as a guide only. Actual settings will depend on the machine, material thickness, gas used and the operator techniques.

### SL-70C Packaging Data

Part No	Wire Diameter (mm)	Pack Description	Weight	Pallet Size
2152	1.2mm	Spool/Carton	15kg	62 Spools
2153	1.6mm	Spool/Carton	15kg	62 Spools

