



# Smoothcor 70T-4

## Classification:

E70T-4 per AWS A5.20, SFA 5.20.

## Description:

**Smoothcor 70T-4** is a carbon steel, flux cored electrode for use without external gas-shielding in multiple pass welding of carbon steels. This electrode is intended for flat position welding of grooves and fillets and horizontal fillet welding with extremely high deposition rates.

## Characteristics:

**Smoothcor 70T-4** is a self-shielded, flux cored electrode intended to weld with a globular transfer, moderate spatter, and high deposition rates. The highly basic slag minimizes hot cracking on steels high in sulfur. Joint penetration is not as great as with E70T-1 electrodes, which facilitates welding fillets with gaps or poor fit up. Slag detachment is quite good, and the bead profile is slightly convex.

## Applications:

**Smoothcor 70T-4** is ideal for those welding applications where gas-shielded electrodes may have problems, such as outdoors or in windy conditions. These would typically be light gauge steel plate fabrication or general purpose fabrication of carbon steels. Select 74 is also a good choice in poor fit up situations or when extended stickouts need be used in hard-to-reach areas.

## Typical Mechanical Properties:

Ultimate Tensile Strength (psi):	87,800
Yield Strength (psi):	65,000
Percent Elongation:	26.5

## Typical Deposit Composition:

Wt%	C	Mn	Si	P	S	Al
	.20	.50	.17	.008	.003	1.59

## Recommended Welding Parameters (use DCEP):

### Optimum

Dia. (in)	Amps	Volts	Wire Feed Speed	CTWD
5/64"	250	29/30	185	2¾"
3/32"	350	29/30	190	2¾"
7/64"	400	30/31	180	2¾"
.120"	450	30/31	135	2¾"

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.