



# Smoothcor<sup>®</sup> 70T-1

**Classification:** AWS A5.20 / ASME SFA 5.20 E70T-1C/E70T-1M

**Description:** Smoothcor 70T-1 is flux core wire designed for single and multiple pass welding of 70,000 psi, high tensile steels, in the flat and horizontal positions with outstanding mechanical properties. Applications include machineries, shipbuilding, offshore structures, bridges and general fabrications. Smoothcor 70T-1 has excellent deposition rates and provides a smooth arc and low spatter. The preferred shielding gas is 100% CO<sub>2</sub> but Ar/15-25% CO<sub>2</sub> can be used. 35-50 cfh.

### Typical Deposit Chemistry: %

	C	Mn	P	S	Si
CO <sub>2</sub>	.05	1.14	.014	.005	.30

### Typical Mechanical Properties:

Tensile Strength (psi)	84,200
Yield Strength (psi)	74,500
Elongation %	27.4
CVN (ft•lbs f) @ -20F	38.4

### Typical Welding Parameters – Carbon & Low Alloy – Flat & Horizontal – CO<sub>2</sub> - DCEP

Dia.	Operating Range			Optimum			
	Amps	WFS (ipm)	Volts	Amps	WFS (ipm)	Volts	ESO
.045"	130-330	160-670	21-32	250	450	28	½" – 1"

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.