



## Smoothcor<sup>®</sup> 70T-4

**Classification:** AWS A5.20 / ASME SFA 5.20 E70T-4

**Description:** Smoothcor 70T-4 is a self- shielded, flux cored wire designed for multiple pass welding of carbon steels. It is intended for flat position weld of grooves and fillets and horizontal welding with extremely deposition rates. Smoothcor 70T-4 is used in outdoor windy conditions where gas shielded welding may be difficult, typically on light gauge steel plate fabrication of carbon steels. It is also a good choice in poor fit up situations or when extended stickouts must be used in hard to reach areas. Smoothcor 70T-4 minimizes hot cracking on steels high in sulfur and has good slag detachment.

### Typical Deposit Chemistry: %

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

### Typical Mechanical Properties:

Tensile Strength(psi)	87,800
Yield Strength (psi)	65,000
Elongation	26

### Typical Welding Parameters – Carbon & Low Alloy – Flux Cored – Flat & Horizontal - DCEP

Dia.	Operating Range			Optimum		
	Amps	Volts	ESO	Amps	WFS (ipm)	Volts
3/32"	250-350	28-33	2 3/4"	350	190	30

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.