



Unibraze 70T-5

Specifications: E70T-5C-H4, E70T-5M-H4 per ANSI/AWS A5.20, ASME SFA 5.20

Description: Unibraze 70T-5 is a flux cored electrode designed with a basic slag system which provides better mechanical properties and diffusible hydrogen levels in the weld deposit than E70T-1 electrodes. It is intended for single and multiple pass welding of carbon and certain low alloy steels where a minimum tensile strength of 70,000 psi and good low temperature notch toughness are required. Unibraze 70T-5 is used to fabricate heavy sections such as crane sections, heavy machine bases, boom assemblies and construction equipment.

Typical steels welded with this electrode are ASTM A36, A285, A515 Gr. 70 and A516 Gr. 70.

Welding Positions: Flat and Horizontal

Characteristics: Excellent weld metal properties.
Slag removal and bead geometry similar to E7018 electrodes.
Low diffusible hydrogen levels.

Typical Chemistry

	<u>C</u>	<u>Mn</u>	<u>P</u>	<u>S</u>	<u>Si</u>
CO ₂	.05	1.29	.009	.010	.44
75 Ar/25 CO ₂	.04	1.46	.008	.010	.57

Typical Mechanical Properties

	<u>CO₂</u>	<u>75 Ar/25 CO₂</u>
Tensile Strength	81,400 psi	87,000 psi
75 Ar/25 CO ₂	68,200 psi	71,800 psi
% Elongation	30	28
CVN (ft•lb f) @ -20° F	77	79

Recommended Welding Parameters

<u>Diameter</u>	<u>Amps</u>	<u>Volts</u>	<u>WFS</u>
1/8"	475	28	115
3/32"	400	28	185
5/64"	370	28	250
1/16"	300	29	320
.045"	250	28	380