



Smoothcor[®] 70T-2

Classification: AWS A5.20 / ASME SFA 5.20 E70T-2C

Description: Smoothcor 70T-2 is a carbon steel, flux cored wire that provides clean, porosity-free, welds on heavily oxidized steels and steels with certain glass coatings. It is designed for single and multiple pass welding in flat and horizontal positions. Smoothcor 70T-2 is recommended for high speed welds on thin gauge carbon steels, particularly lap and butt welds. Applications include, wheel and hub assemblies and hot water heater weldments. Shielding gas: 100% CO₂. 44-55 cfh.

Typical Deposit Chemistry: %

C	Mn	P	S	Si
.06	1.52	.02	.03	1.02

Typical Mechanical Properties:

Transverse Tensile Strength (psi)	85,700 (base metal fracture)
Guided Bend Test	Meets AWS requirements

Typical Welding Parameters – Carbon & Low Alloy – Flat & Horizontal – CO₂ - DCEP

Dia.	Operating Range			Optimum			
	Amps	WFS (ipm)	Volts	Amps	WFS (ipm)	Volts	ESO
3/32"	300-550	110-270	26-34	425	180	29	¾" – 1 ¼"
1/8"	450-880	75-180	30-36	600	125	32	¾" – 1 ¼"

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.