

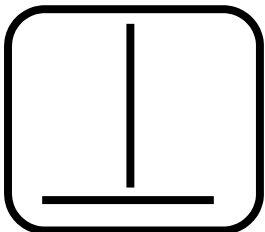
## CHARACTERISTICS :-

Fine 70-is a Basic type Co<sub>2</sub> gas shielded flux cored welding wire. It Provides excellent performance in welding: slag easy to remove, low spatters, stable arc & bead appearance is good. The wire is suitable for Flat & Horizontal position welding.

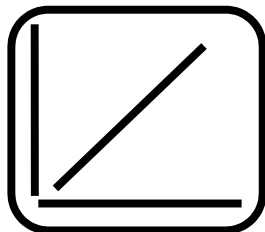
## APPLICATION :-

Welding of mild steels and carbon steels with specified tensile strength up to 500 N/mm<sup>2</sup> for fabrication of machinery, structure, steel frames, ships, Boilers, Pressure Vessel, Auto Parts, Bridges & Chemical Plant etc.

## WELDING POSITION :-



1G



2F

## CHEMICAL COMPOSITION OF WELD METAL

Element	C%	Mn%	Si%	S%	P%	Ni%
Typical Values	0.05	1.41	0.40	0.010	0.018	0.030
Spec. Reqd.	0.12 Max	1.75 Max	0.90 Max	0.03 Max	0.03 Max	0.50 Max

## MECHANICAL PROPERTIES OF WELD METAL

Property	U.T.S. (N/mm <sup>2</sup> )	Y.S.(N/mm <sup>2</sup> )	ELONGATION(L = 4d)%	CVN IMPACT AT - 30°C (J)
Typical Values	550	470	26	60
Spec. Reqd.	480 Min	400 Min	22 Min	27 Min

## WELDING PARAMETERS (DC + VE): -

Diameter(mm)	Flat & Horizontal(A)	Flat & Horizontal(V)
1.20	180 - 250	26 - 30
1.60	210 - 280	26 - 30

Packing : - 15 kgs. Spool Vacuum Packed