

Standards

TS EN ISO 17632-A	: T 42 4 B C M 3 H5
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AWS A5.20	: E 70T-5C/-5M H4

**Chemical Composition of
Weld Metal (Typical)**

C	Si	Mn
0.05	0.60	1.40

Mechanical Properties

Heat Treatment	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength		Elongation ((L ₀ =5d ₀) (%))
			(ISO-V/-20°C)	(ISO-V/-40°C)	
AW or SR	min. 470	550 - 640	min. 100 J	min. 60 J	min. 27

AW: as welded SR: stress relieved

Typical Base Material Grades

- EN: S185, S235-S355, P 235 GH, P 265 GH, P 295 GH, P 235 T1/T2-P355N, I2 10-L485, S 255-S460, X42-X70
- ASTM: A 131, A106/A515/A 714, A283/A285/A414/A662/A372, A369/A210/ A106, A516/A255/A 333/ A350

Features and Applications

- ELCOR B 70 SC is high-basidity flux-cored wire
- Extremely crack resistant weld metal conditioned by the basic slag
- High mechanical properties are easily obtained when used in single-sided welding operations using a ceramic back-up
- Weld has X-ray quality with low spatter formation. Well-suited for joining high carbon steels and when welding critical mixed base metal combinations
- Ideal metallurgical choice for repair welding and production as well as for use as a buffer layer
- Shielding gas; CO₂ or M21

Welding Positions

Current Type

FCAW / D.C. (+)

Operating Data

Diameter (mm) / (inch)		Weight (Kg)	Package Type
1.20	0.047"	15	BS 300