GeKa®

Seamless Metal Cored Wire

ELCOR M 70 SC

Standards

TS EN ISO 17632-A	: T 46 6 M M 1 H5
EN ISO 17632-A	: T 46 6 M M 1 H5
AWS A5.18	: E 70 C-6 M H4

Chemical Composition of Weld Metal (Typical)

C	Si	Mn
0.05	0.7	1.5

Mechanical Properties - (Typical): (Typical values : with M21 gas)

Heat Treatment	Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/-40°C)	Impact Strength (ISO-V/-60°C)	Elongation ($(L_o=5d_o)$ (%)
AW or SR	min. 460	530 - 650	min. 60 J	min. 47 J	min. 26

AW: as welded **SR:** stress relieved

Typical Base Material Grades

- S235JR, S275JR, S235J2G3-S355J2G3, P 235T1-P355T1, P235T2-P355T2, L210NB-L415NB, L290MB-L415MB, P235G1TH, P255G1TH, P235GH-P355GH, P295GH, S235JRS1-S235J4S, S315G1S-S355G3S, S255N-S420N, S255NL-S355NL, GE200-GE260, X42-X70

Features and Applications

- Good arc restriking even with cold wire tip, suitable for robot applications
- Multi-pass welding without in-between cleaning
- Ideal for use in the field short arc and spray arc
- Excellent gap bridging for root welding
- Typical applications are shipbuilding, steel and pressure vessel construction, mechanical engineering and pipe work
- High-efficiency type for economic production
- Shielding Gas: M21

Welding Positions

Current Type

FCAW / D.C.(+)

Operating Data

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