

CORDIFF 70T4

Characteristics:

CORDIFF 70T4 is a self-shielded flux cored wire designed with slag system to produce weld with very low sulphur and resistance to hot cracking. It has good operator appeal with slag cover, stable arc and optimized performance characteristics. The deposit has superior crack resistance and suitable for welding steels with high sulphur and carbon steels. Low spatter loss with easy slag removal.

Applications:

Suitable for single and multipass welding of low and medium carbon steels. Joining of Structural steels, mild steels, and low alloy steels. Used for general fabrication steels. Also suitable for welding IS:2062, st.32.3 to st.52.4.

Classification:

SFA/AWS A5.20 – E70T4

Typical Chemical Composition:

C	Si	Mn
0.09	0.30	0.95

Mechanical Properties:

Tensile Strength	Yield Strength	% Elongation
525 – 655 N/ mm ²	420 N/ mm ² (min.)	22% (min.)

WELDING PARAMETERS:

Polarity: DC + ve

SHIELDING GAS: 100% CO₂ or 80%Ar/Balance CO₂

DIA. (mm)	VOLTAGE	AMPS
1.2	20 – 26	110 – 180
1.4	22 – 28	130 – 220
1.6	24 – 30	160 – 250

STANDARD PACKING:

Spool = 12.5 kgs(± 1kg) Spool = 15 kgs(± 1kg) Spool = 25 kgs(± 1kg)

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