tkM 70-MC

Metal-filled cored wire

Classification	EN ISO 17632-A	AWS A 5.18
	T 46 4 M M21 2 H5	E70C-6M

Technical description

High-quality metal-filled cored wire for welding unalloyed steels. Provides stable arc, low spatter and low glaze on the weld face. Post-weld cleaning before applying a coating or painting is highly reduced. Recommended for welding thin sheets in mechanized or automated processes, including robots. It also works well during manual welding of thicker plates.

The wide range of operating parameters is another great advantage, it allows to control the arc and gives very good quality of welds. Significantly higher efficiency than MAG solid welding wires.

tkM 70-MC wire operates at a low arc voltage, which, combined with a high travel speed, gives lower heat input, thus reducing the problem of deformation of welded elements, which occurs when working with conventional MIG/MAG methods with thinner materials.

Gives a low content of diffusible hydrogen in the weld metal (below 4.0ml/100gl).

Base materials:

Steels up to the yield point < **460 MPa**

S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M, P235GHP355GH, P275NL1-P460NL1, P215NL, P265NL, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2- P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE240

Ship steels: A, B, D, E, F, A 4

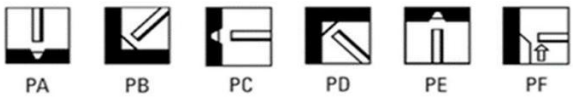
Typical wire composition (%)

C	Si	Mn	S	P	Cu
0,04	0,65	1,6	0,02	0,016	0,018

Mechanical properties of all-weld (min. values at ambient. temp, shield gas M21)

Yield strength 0,2% N/mm²	Tensile strength N/mm²	Elongation ($L_0 = 5d_0$) %	Impact value in J KCV -40 °C
480	**560**	**27**	**75**

Welding positions:



Polarity: =+

Shield gas: Ar + (15÷25% CO_2)

Dimensions (mm)/ packing

1,0 – 1,6

15kg spol D300 / BS300