

Artikelnummer	Omschrijving
09000002	MIG FCW Supercored 70NS 1,2mm Hyundai
09000003	MIG FCW Supercored 70NS 1,4mm Hyundai
09000024	MIG FCW Supercored 70NS 1,6mm Hyundai

Supercored 70NS

TYPE : Metal-Cored

AWS A5.18 / ASME SFA5.18 E70C-6M
JIS Z3313 T49 3 T15-0 M A H5
EN ISO 17632-A-T 42 3 M M 3 H5

Toepassingen

Gevulde lasdraad voor de scheepsbouw en bruggen industrie. Ideaal voor automatisatie met robot.

Characteristics on Usage

Supercored 70NS is a metal-cored wire which combines the high deposition rates of F.C.W with the high efficiencies of a solid wire, provides exceptionally smooth and stable arc, low spatter and minimal slag coverage.

Notes on Usage

- ① Proper preheating(50~150° C)(122~302° F) and interpass temperature must be used in order to release hydrogen which may cause cracking in weld metal when electrodes are used for medium and heavy plates.
- ② One-side welding defects such as hot cracking in may occur with wrong welding parameter such as high welding speed.
- ③ Use Ar+20~25% CO₂ gas.

Welding Position



1G 2F 3G
(PA) (PB) (PF)

Current

DC +

Shielding Gas

Ar+20~25%CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.05	0.55	1.45	0.013	0.010

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
480 (69,700)	550 (79,900)	27.0	-30 (-22)	50 (37)

Approval

ABS, LR, BV, DNV, GL, TÜV,
CWB, CE, DB, RINA

I Packing(Including Ball Pac)

Dia. (mm)	1.0	1.2	1.4	1.6
(in)	.039	.045	.052	1/16

Spool(kg)	12.5	15	20
(lbs)	28	33	44

Sizes Available and Recommended Currents (Amp.)

Size mm(in)	1.2 (.045)	1.4 (.052)	1.6 (1/16)
F & HF	230~300	260~340	290~360

FCAW

Artikelnummer	Omschrijving
09000007	MIG FCW Supercored 70ML 1,2mm Hyundai
09000008	MIG FCW Supercored 70ML 1,4mm Hyundai
09000055	MIG FCW Supercored 70ML 1,6mm Hyundai

SC-70ML	AWS A5.18/ ASME SFA5.18 E70C-6M JIS Z3313 T49 4 T15-1 M A-U H5 EN ISO 17632-A-T 46 4 M M 2 H5
TYPE : Metal-Cored	

Toepassingen


Gevulde lasdraad voor mild staal en staal met hoge treksterktes. Ideaal voor zware en hoge constructies, geautomatiseerd gebruik.

Characteristics on Usage

SC - 70ML is a gas shielded metal-cored wire which combines high deposition rates of a flux cored wire with high efficiency of a solid wire. Its design achieves low temperature impacts and can be used in semiautomatic and automatic applications.

Notes on Usage

- ① Use Ar + 20 ~ 25% CO₂ gas.

Welding Position	Current	Shielding Gas
 1G (PA) 2F (PB) 3G (PF) 4G (PE)	DC +	Ar+20~25%CO ₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni
0.05	0.57	1.56	0.013	0.010	0.42

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
510 (73,950)	560 (81,200)	27.0	-40 (-40)	70 (52)

Approval	I Packing
ABS, LR, DNV, BV, GL TÜV, DB, CE, CWB	Dia. (mm) 1.2 1.4 1.6 (in) .045 .052 1/16 Spool(kg) 15 (lbs) 33

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.2 (.045)	1.4 (.052)	1.6 (1/16)
F & HF	200 ~ 300	260 ~ 340	300 ~ 350
V-up, OH	100 ~ 150	140 ~ 180	150 ~ 180

FCAW

Artikelnummer	Omschrijving
09000010	MIG FCW Supercored 71MAG 1,2mm Hyundai
09000011	MIG FCW Supercored 71MAG 1,4mm Hyundai

Supercored 71MAG

TYPE : Rutile

AWS A5.20 / ASME SFA5.20 E71T-1M/-9M
 JIS Z3313 T49 3 T1-1 M A-U H10
 EN ISO 17632-A-T 46 3 P M 1

Toepassingen


Gevulde lasdraad voor de bouw, bruggen, machines en auto-industrie.

Characteristics on Usage

Despite welding position, it will get low spatter, soft arc, good bead appearance and excellent weldability with this wire.

Notes on Usage

- ① Proper preheating(50~150° C)(122~302° F) and interpass temperature must be used in order to release hydrogen which may cause cracking in weld metal when electrodes are used for medium and heavy plates.
- ② One-side welding defects such as hot cracking may occur with wrong welding parameter such as high welding speed.
- ③ Use Ar+20~25% CO₂ gas.

Welding Position	Current	Shielding Gas
 1G 2F 3G 4G (PA) (PB)(PF.PG)(PE)	DC +	Ar + 20~25% CO ₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.04	0.54	1.25	0.011	0.012

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
580 (84,200)	600 (87,100)	28	-30 (-22)	60 (44)

Approval I Packing(Including Ball Pac)

Approval	Dia. (mm)	1.0	1.2	1.4	1.6	Spool(kg)	12.5	15	20
ABS, LR, BV, DNV, GL, TÜV, CE, DB, RINA, CWB	(in)	.039	.045	.052	1/16	(lbs)	28	33	44

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.2 (.045)	1.4 (.052)	1.6 (1/16)
F & HF	220~290	240~320	260~350
V-up, OH	180~250	200~260	230~290
V-down	210~290	250~320	270~330

Artikelnummer

09000018

Omschrijving

MIG Supercored 70B 1,2mm Hyundai

Supercored 70B

TYPE : Basic

AWS A5.20 / ASME SFA5.20 E71T-5M-J
JIS Z3313 T49 4 T5-1 M A-U H5
EN ISO 17632-A-T 42 4 B M 3 H5

Toepassingen

Gevulde lasdraad met hoge treksterkte voor scheepsbouw, machines en bruggen, zware constructies.

Characteristics on Usage

Supercored 70B is a basic type flux cored wire with excellent characteristics and is suitable for steel with tensile strength up to 600MPa. Deposited metal shows superior crack resistance, excellent toughness at low temperature of -20~-50° C (-4~-58° F).

Notes on Usage

- ① Proper preheating(50~150° C)(122~302° F) and interpass temperature must be used in order to release hydrogen which may cause cracking in weld metal when electrodes are used for medium and heavy plates.
- ② Use Ar+20~25% CO₂ gas for welding.

Welding Position



1G 2F 3G 4G
(PA) (PB) (PF) (PE)

Current

DC ±

Shielding Gas

Ar+20~25%CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.06	0.43	1.33	0.011	0.013

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
450 (65,300)	520 (75,400)	32	-40 (-40)	78 (58)

Approval

ABS, DNV, BV, GL, LR
TÜV, DB, CE

I Packing(Including Ball Pac)

Dia. (mm)	1.0	1.2	1.4	1.6	2.0	Spool(kg)	12.5	15	20
(in)	.039	.045	.052	1/16	5/64	(lbs)	28	33	44

Sizes Available and Recommended Currents (Amp.)

Size mm(in)	1.0 (.039)	1.2 (.045)	1.4 (0.52)	2.0 (5/64)
F & HF	150~280	170~320	200~350	200~400
V-up,OH	70~130	80~150	90~180	

Artikelnummer

09000027

Omschrijving

MIG Supercored 81MAG 1,2mm Hyundai

Supercored 81MAG

TYPE : Rutile

AWS A5.29 / ASME SFA5.29 E81T1-Ni1M H4
EN ISO 17632-A-T 46 6 1 Ni P M 2 H5

Toepassingen

Gevulde lasdraad voor gebruik in olie en gas piping industrie en buitenconstructies.

Characteristics on Usage

Supercored 81MAG is a titania type flux cored wire to be used with Ar+CO₂ gas mixture shielding. This provides excellent notch toughness at low temperature, not only as-welded but also stress relieved state.

Notes on Usage

- ① Proper preheating (50~150° C)(122~302°F) and interpass temperature must be used in order to release hydrogen which may cause cracking in weld metal when electrodes are used for medium and heavy plates.
- ② One-side welding defects such as hot cracking may occur with wrong welding parameter such as high welding speed.
- ③ Use Ar+20~25% CO₂ gas.

Welding Position



1G 2F 3G 4G
(PA) (PB) (PF) (PE)

Current

DC +

Shielding Gas

Ar+20~25%CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni
0.05	0.28	1.20	0.008	0.012	0.93

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
550 (79,900)	590 (85,700)	26	-60 (-76)	60 (44) As welded
510 (74,100)	570 (82,800)	28	-40 (-40)	98 (73) PWHT(620° C x 2hr)

Approval

ABS, BV, DNV, LR, CWB,
RINA, MRS, TÜV, DB, CE

I Packing

Dia. (mm) 1.2 1.6
(in) .045 1/6

Spool(kg) 12.5 15 20
(lbs) 28 33 44

Sizes Available and Recommended Currents (Amp.)

Size mm(in)	1.2 (.045)	1.6 (1/16)
F & HF	200~290	260~350
V-up,OH	180~250	230~290
V-down	210~280	270~330

FCAW