

ROYALFIL OA 70T-4 (E70T-4)

AWS A / SFA 5.20 E70T-4 CEN / ISO 17632 A T423BC3H5

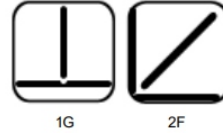
Applications

RoyalFil OA 70-T4 is a self shielded, high deposition rate fluxcored wire for flat & horizontal fillet welding with globular type transfer. .

Characteristics on Usage

RoyalFil OA 70-T4 is used for welding of general fabrication, structural fabrication, civil construction, building / repairing of heavy machineries / heavy equipments.

Welding Positions



Recommended Stick Out
30-40 mm

FLUX CORED WIRE : CARBON STEEL

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Al%
0.30Max	1.75Max	0.60Max	0.030Max	0.030Max	1.80Max

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %
585-670 Min	390-490 Min	22-24.5Min

Packing and Welding Current

SIZE (mm)	Flat & Horizontal (A)	Flat & Horizontal (A)
2.40	250-350	28-32
2.80	350-400	28-32

Packing

Drum packing in 100 Kgs /250 Kgs.