

## OA S-70-T4R

**CATEGORY** FCAW Flux-Cored

**TYPE** Welding wire developed for welding without protective gas with high deposition rate.

**APPLICATIONS** Welding outside in case high speed welding is required and protective gas is not possible or difficult. Suitable for C-Mn steels such as rails, fabrication of machinery, steel framed buildings and or heavy equipment repair. Recommended for butt assembly of rails and crossings.

**PROPERTIES**

- Very good welding characteristics and not sensitive for contaminations.
- Good mechanical properties and high crack resistance.
- Deposition rate up-to 20 kg/h.
- For single and multiple-pass welding of C-Mn steels.
- Excellent self shielding properties.

**CLASSIFICATION**

AWS	A 5.20: E 70 T-4
EN ISO	758: T 38 Z W N 3

**SUITABLE FOR** Rebuilding and joining steel parts that requires good strenght and high productivity.

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

C	Mn	Si	Al	S	P
0.20	0.55	0.20	1.30	0.002	0.002

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	450	610	25				

AW: as welded

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	spools type	kg / spools
1.6	19-27	150-280	BS-300 / Coil / Drum	25 / 330
2.0	25-32	200-400	BS-300 / Coil / Drum	25 / 330
2.4	26-34	300-500	BS-300 / Coil / Drum	25 / 330

**REDRYING TEMPERATURE** 150°C / 24hr.

**NOTE** Weld metal toughness has to be considered.