

# KOBELCO

## FAMILIARC™

# MX-A70C6LF

**Highly efficient metal-cored wire for carbon steel**



**High deposition rate with excellent weldability is created by a wide spray-transfer range**

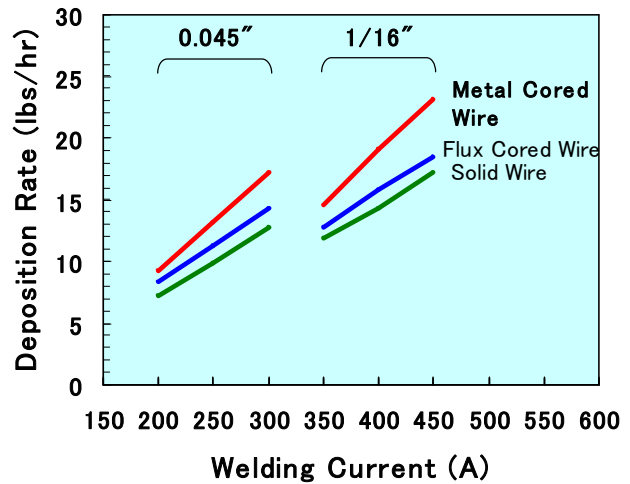
### Code Data

**AWS/ASME A5.18 E70C-6MH4**

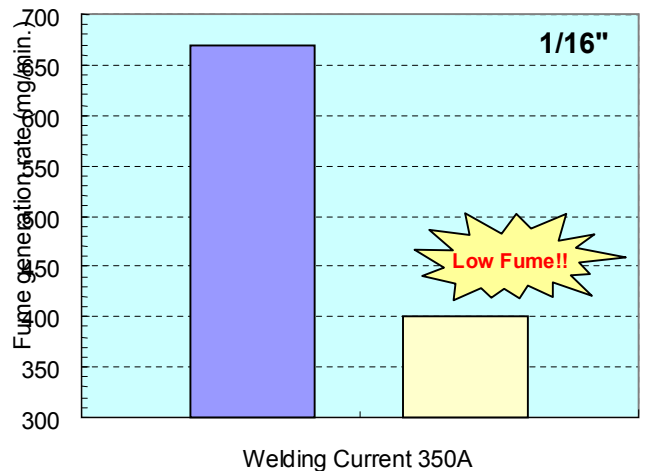
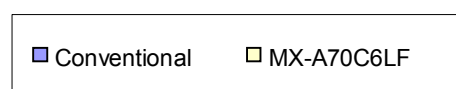
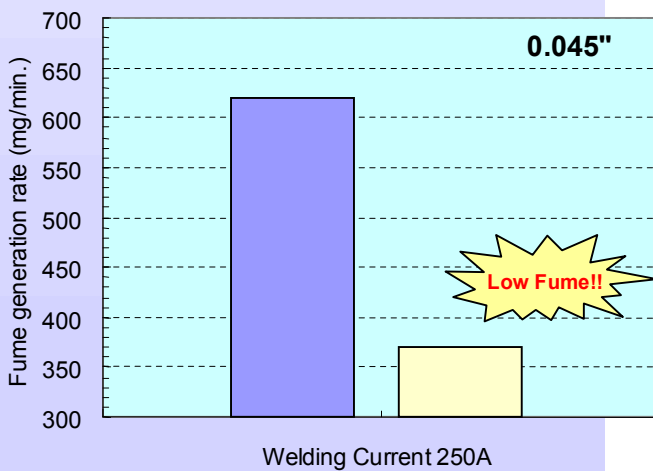
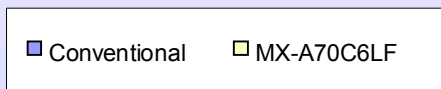
**CWB W48-06 E492C-6M-H4**

### Outstanding Features

- MX-A70C6LF has lower fume and spatter generation than conventional metal cored wire.
- Its cored metal powder has higher deposition rates than solid wire or even flux cored wire.



Typical deposition rate of welding consumables



Fume generation (90%Ar-10%CO<sub>2</sub>)

**Typical chemistry of weld metal and diffusible hydrogen content (Wire size 1/16")**

Shielding gas	C	Si	Mn	P	S	Diffusible hydrogen content (ml/100g)
80%Ar-20%CO <sub>2</sub>	0.04	0.79	1.62	0.008	0.009	2.9
95%Ar-5%CO <sub>2</sub>	0.04	0.85	1.69	0.007	0.010	3.5

Gas chromatography method (AWS A4.3)

**Typical mechanical property of weld metal (Wire size 1/16" 340A)**

Shielding gas	0.2%P.S (psi)	T.S (psi)	Elongation (%)	Impact value (ft-lbs)	
				-50 °F	-20 °F
80%Ar-20%CO <sub>2</sub>	64,700	80,400	34	58*	96
95%Ar-5%CO <sub>2</sub>	66,600	81,900	34	-	101

\* Wire size 0.045" 280A

**Recommended welding condition**

Wire size (in.)	Wire feeding speed (in./min)	Current (A)	Voltage (V)	Deposition rate (lbs/hr)	Wire stick out (in.)
0.045	300	200	28-31	7.5	5/8" - 3/4"
	375	240	29-33	9.5	
	435	280	30-34	11.0	
	530	320	32-36	13.5	
	620	360	33-37	15.5	
0.052	250	230	27-29	8.5	3/4" - 1"
	300	270	28-32	10.5	
	400	320	30-34	14.0	
	460	370	31-36	16.0	
	545	420	32-37	19.0	
1/16	165	260	27-29	7.5	3/4" - 1"
	245	320	28-33	11.5	
	350	380	29-35	17.0	
	415	440	30-36	20.0	
	490	500	31-37	24.0	