

DESCRIPTION

Executive 70S-A1 is designed to weld 0.5% Mo and other fine grained steels using MIG and TIG welding processes where low temperature service in the as welded condition is required. The weld deposits offer good strength at elevated temperatures up to 900°F (-517°C) along with excellent resistance to cold cracking.

Executive 70S-A1 filler metal is produced using high quality raw materials and tightly controlled chemistry to provide top quality, exceptionally clean wires that deliver smooth feedability and the results fabricators demand.

APPLICATIONS & FEATURES

Suitable for welding low alloy steels with high tensile strength for pipeline and pressure vessel applications where service temperatures up 900°F (-517°C).

Typical materials include ASTM A204, A335-Gr 1, API 5 L B X42, X52, X60 and X65.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Mn	Si	Cr	Mo	P	S	Cr	Cu	Ni	Al	Ti	V	Zr	Nb
0.085	1.08	0.620	0.06	0.42	0.008	0.009	0.06	0.120	0.04	0.003	0.001	0.003	0.0007	0.001

Tensile Strength: 78,000 PSI min **Yield Strength:** 59,000 PSI min **Elongation:** 19%
Charpy V-Notch:

TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Speed (in/min)	Shielding Gas / Flux	
GMAW - Short	.035"	14-20	90-160	100	100% CO ₂	
	.045"	16-20	120-200	150	75% Ar / 25% CO ₂	
	- Spray	.035"	25-28	180-230	125	98% Ar / 2% O ₂
		.045"	25-30	250-350	150	75% Ar / 25% CO ₂
GTAW	.093"	Direct Current; Electrode -				100% Ar
	.125"					

STANDARD PACKAGING

GMAW (MIG)	33-lb plastic spools	1,980-lb pallet
GTAW (TIG)	10-lb plastic tube	40-lb box

CLASSIFICATION

AWS/SFA 5.28, Class **ER70S-A1**

