

Data Sheet

Flux cored wire

Materials Services
Materials Ibérica

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Designation	Name	Material No.
TI E70C-6M H5	E70C-6M	

Approvals

EN ISO 17632-A: T46 4 M M21 3 H5

AWS A 5.18: E70C-6M

JIS Z 3313 T 49 4 T15-0 M A-U



Characteristics and Applications:

TI E70C-6M is a gas shielded metal cored wire that features smooth spray arc, low slag volume, low spatter, low diffusible hydrogen low fume emission and excellent low temperature impact toughness down to -40°C. It welds with a wider penetration profile and higher deposition efficiency than solid wire.

Typical chemical composition of weld metal (wt%):

C	Mn	Si	P	S
0.04	1.45	0.54	0.010	0.008

Typical mechanical properties of weld metal:

Yield strength MPa (Ksi)	Tensile strength MPa (ksi)	Elongation (%)	Charpy V-Notch J (ft-1bf) -30 (-20°F)
480 (70)	550 (80)	26	65 (48)

Sizes and recommended current range (DC <+>):

Stick out: 15-25 (mm), flow rate: 20-25 (l/min)

Parameters \ Diameter (mm)	1.2	1.4	1.6
F	240A~320A / 26V-34V	260A~340A / 27V-34V	270A~360A / 28V-35V

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