

**Characteristics and Applications:**

Hobart 70T is a high deposition rate flux cored wire suitable for high speed fillet welding application in flat and horizontal position. The wire has excellent porosity resistibility for use in welding over zinc-primer surface and mill scale in high speed fillet welding. The wire generates low spatter and produces thinner slag with good slag detachability. In addition it produces deep effective throat on fillet weld and it has good arc stability and welder appeal.

Hobart 70T is widely used in shipbuilding, bridge construction and structural fabrication.

**Notes on Usage:**

1. Proper pre-heating 50~150°C (120~300°F) and inter-pass temperature must be used in order to release hydrogen which may cause cracking in weld metal when welding on medium and heavy plates.
2. Use DC(+) polarity and 100% CO<sub>2</sub> shielding gas.
3. Maintain the temperature of inter-pass under 150°C when in multiple-pass welding.
4. Keep dry while in storage and delivery.

**Typical chemical composition of weld metal (wt%)**

C	Mn	Si	P	S
0.05	1.55	0.60	0.017	0.007

**Typical mechanical properties of weld metal**

YS (MPa)	TS (MPa)	EL %	CVN (J)	
			-20°C	-30°C
550	595	27	90	70

**Welding position****Sizes and recommended current range ( DC <+> )**

**Stick out: 15~25 (mm) , flow rate: 15~25 (L/min)**

Diameter (mm)	1.2	1.4	1.6
F、H	160A-300A / 24V-36V	200A-350A / 26V~34V	270A-400A / 28V-40V