

PRODUCT DATA SHEET

Subarc Sub 70-I



Afrox Sub 70-I is a copper coated CMn submerged arc welding wire for joining carbon manganese steels. It is widely used in structural steel work, i.e. shipbuilding, construction work, etc. The wire is suitable for both single-pass and multi-pass welding, and for welding butt and fillet joints where maximum ductility is required.

Classifications

AWS	A5.17-89	EL 12
EN	756	SI

Typical Chemical Analysis (All weld metal)

% Carbon	0,078	% Phosphorous	0,009
% Manganese	0,46	% Sulphur	0,02
% Silicon	0,093	% Copper	0,2

Typical Chemical Analysis Weld Metal (SA 516 GR 70 Plate)

Flux	HPF-N90	HPF-A72	MK-N
% Carbon	0,042	0,066	0,06
% Manganese	1,144	1,259	0,81
% Silicon	0,346	0,628	0,37
% Phosphorous	0,034	0,031	0,024
% Sulphur	0,025	0,026	0,019
% Copper	0,242	0,259	0,28

Typical Mechanical Properties (All weld metal in the as welded condition)

Flux	HPF-N90	HPF-A72	MK-N
Flux/Wire Combination	F7A5-EL12	F7A0-EL12	F7A2-EL12
Tensile Strength	516 MPa	615 MPa	526 MPa
Yield Strength	425 MPa	519 MPa	441 MPa
% Elongation on 4d	31	27	32
Charpy Impact Value	43 J at -49°C	40 J at -18°C	51 J at -29°C

Packing Data

Saw Wire	Current (DC+/AC)		Pack Mass (kg)	Item Number
	Diameter (mm)	Amps (A)		
2,0	400	28	25,0	W080011
2,4	450	28	25,0	W080012
3,2	500	28	25,0	W080013
4,0	550	28	25,0	W080014

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