



# CEWELD OA S-70-T4R

|                                             |                                                                                                                                                                                                                                                                                                                                                              |                           |                      |                    |          |     |
|---------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------|----------------------|--------------------|----------|-----|
| TYPE                                        | Welding wire developed for welding without protective gas with high deposition rate.                                                                                                                                                                                                                                                                         |                           |                      |                    |          |     |
| APPLICATIONS                                | Welding outside in case high speed welding is required and protective gas is not possible or difficult. Suitable for C-Mn steels such as rails, fabrication of machinery, steel framed buildings and or heavy equipment repair. Recommended for butt assembly of rails and crossings.                                                                        |                           |                      |                    |          |     |
| PROPERTIES                                  | CEWELD OA S-70-T4R is able to Weld out of position at extreme currents and offers a Low hydrogen weld deposit. Excellent slag removal and protective gas is not required. High impact strength at low temperatures combined with excellent mechanical properties within a wide range of heat inputs. Usable under AWS D1.8 for use on Demand Critical welds. |                           |                      |                    |          |     |
| CLASSIFICATION                              | AWS                                                                                                                                                                                                                                                                                                                                                          | A 5.20: E70T-4            |                      |                    |          |     |
|                                             | EN ISO                                                                                                                                                                                                                                                                                                                                                       | 17632-A: T 38 Z W N 3 H15 |                      |                    |          |     |
|                                             | F-nr                                                                                                                                                                                                                                                                                                                                                         | 6                         |                      |                    |          |     |
|                                             | FM                                                                                                                                                                                                                                                                                                                                                           | 1                         |                      |                    |          |     |
| SUITABLE FOR                                | Rebuilding and joining steel parts that requires good strenght and high productivity.                                                                                                                                                                                                                                                                        |                           |                      |                    |          |     |
| APPROVALS                                   |                                                                                                                                                                                                                                                                                                                                                              |                           |                      |                    |          |     |
| WELDING POSITIONS                           | <div>PAPB</div>                                                                                                                                                                            |                           |                      |                    |          |     |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | C                                                                                                                                                                                                                                                                                                                                                            | Si                        | Mn                   | P                  | S        | Al  |
|                                             | 0.2                                                                                                                                                                                                                                                                                                                                                          | 0.2                       | 0.55                 | 0.002              | 0.002    | 1.3 |
| MECHANICAL PROPERTIES                       | Heat Treatment                                                                                                                                                                                                                                                                                                                                               | R <sub>P0,2</sub> (MPa)   | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Hardness |     |
|                                             | As Welded                                                                                                                                                                                                                                                                                                                                                    | 450                       | 610                  | 25                 | HRc      |     |
| REDRYING                                    | 140°C / 24 hr                                                                                                                                                                                                                                                                                                                                                |                           |                      |                    |          |     |
| GAS ACC. EN ISO 14175                       |                                                                                                                                                                                                                                                                                                                                                              |                           |                      |                    |          |     |



# CEWELD OA S-70-T4R

OA S-70-T4R 2,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| D-300     | 15      | 8720663406132 |