

ROYALFIL OA 70T-4 (E70T-4)

AWS A / SFA 5.20 E70T-4

Applications

RoyalFil OA 70-T4 is a self shielded, high deposition rate fluxcored wire for flat & horizontal fillet welding with globular type transfer.

Characteristics on Usage

RoyalFil OA 70-T4 is used for welding of general fabrication, structural fabrication, civil construction, building / repairing of heavy machineries / heavy equipments.

Welding Positions

1G

2F

Chemical Composition Of Weld Metal

Element	C%	Mn%	Si%	S%	P%	Al
Typical Values	0.24	0.65	0.40	0.005	0.014	1.25
Spec. Req'd.	0.30 Max	1.75 Max	0.60 Max	0.030 Max	0.030 Max	1.80 Max

Mechanical Properties Of Weld Metal

Property	U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %
Typical Values	585	490	24.5
Spec. Req'd.	490-670	390 Min	22 Min

Welding Parameters (DC + VE)

Diameter (mm)	Flat & Horizontal (A)	Flat & Horizontal (V)
2.40	250-350	28-32
2.80	350-400	28-32

Packing

Drum packing in 100 Kgs / 250 Kgs.