

Dual Shield R-70 ULTRA

This flux cored welding wire produces smoother arc characteristics and lower welding fumes than many competitive flux cored wires. Dual Shield R-70 Ultra is also designed to have a greater tolerance of mill scale and surface oxides. The notch toughness in the as welded condition is also improved. Bead contour is flat to slightly convex and slag coverage is complete. Dual Shield R-70 Ultra wire is designed for flat and horizontal single or multi-pass applications on low or medium carbon steels recommended with 100% CO₂ shielding gas. Areas of application include railcar, heavy equipment, and general fabrication.

Specifications

Classifications	AWS 5.36 : E70T1-M21A2-CS1-DH8 (= or < 1/16") ASME SFA 5.36 ASME SFA 5.20 AWS A5.36 : E70T1-C1A2-CS1-DH8 AWS A5.36 : E70T1-C1A2-CS1-D (> 1/16") AWS A5.20 : E70T-1C-DH8/E70T-1M/E70T-9C-DH8/E70T-9M
Approvals	Seismic Certified "D" CWB : CSA W48 E492T-9-H8 (= or < 1/16), E492T-9M-H16 (>1/16") DNV-GL LR QPL-24403/1 : MIL-70T-1C
Industry	Industrial and General Fabrication Civil Construction Ship/Barge Building Mobile Equipment Railcars

Approvals are based on factory location. Please contact ESAB for more information.

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation	Reduction in Area
100% CO₂				
As Welded	485 MPa (70 ksi)	565 MPa (82 ksi)	26 %	63 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
100% CO₂		
As Welded	-29 °C (-20 °F)	34 J (25 ft-lb)
As Welded	-18 °C (0 °F)	38 J (28 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	S	P
100% CO₂				
0.02	1.40	0.50	0.008	0.014

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Efficiency (%)	Deposition Rate
100% CO₂					
1.2 mm (.045 in.)	145 A	28 V	508 cm/min (200 in./min)	76 %	1.7 kg/h (3.7 lbs/h)
1.2 mm (.045 in.)	225 A	29 V	1016 cm/min (400 in./min)	82 %	3.4 kg/h (7.6 lbs/h)
1.2 mm (.045 in.)	190 A	29 V	762 cm/min (300 in./min)	80 %	2.5 kg/h (5.6 lbs/h)
2.0 mm (5/64 in.)	320 A	30 V	762 cm/min (300 in./min)	84 %	7.4 kg/h (16.2 lbs/h)

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Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Efficiency (%)	Deposition Rate
2.4 mm (3/32 in.)	290 A	27 V	381 cm/min (150 in./min)	87 %	5.8 kg/h (12.7 lbs/h)
2.0 mm (5/64 in.)	235 A	28 V	508 cm/min (200 in./min)	84 %	4.9 kg/h (10.8 lbs/h)
1.6 mm (1/16 in.)	365 A	31 V	889 cm/min (350 in./min)	84 %	5.6 kg/h (12.4 lbs/h)
2.4 mm (3/32 in.)	475 A	32 V	762 cm/min (300 in./min)	85 %	11.3 kg/h (25.0 lbs/h)
2.4 mm (3/32 in.)	220 A	27 V	254 cm/min (100 in./min)	88 %	3.8 kg/h (8.4 lbs/h)
1.2 mm (.045 in.)	300 A	33 V	1524 cm/min (600 in./min)	84 %	5.3 kg/h (11.6 lbs/h)
1.4 mm (.052 in.)	180 A	26 V	508 cm/min (200 in./min)	80 %	2.3 kg/h (5.1 lbs/h)
2.0 mm (5/64 in.)	170 A	27 V	317.5 cm/min (125 in./min)	80 %	3.0 kg/h (6.5 lbs/h)
1.6 mm (1/16 in.)	265 A	28 V	635 cm/min (250 in./min)	83 %	4.0 kg/h (8.7 lbs/h)
1.4 mm (.052 in.)	140 A	25 V	381 cm/min (150 in./min)	79 %	1.8 kg/h (3.9 lbs/h)
1.6 mm (1/16 in.)	450 A	33 V	1270 cm/min (500 in./min)	85 %	8.0 kg/h (17.7 lbs/h)
1.6 mm (1/16 in.)	195 A	26 V	381 cm/min (150 in./min)	78 %	2.3 kg/h (5.0 lbs/h)
1.2 mm (.045 in.)	255 A	32 V	1270 cm/min (500 in./min)	82 %	4.4 kg/h (9.6 lbs/h)
2.0 mm (5/64 in.)	280 A	29 V	635 cm/min (250 in./min)	85 %	6.2 kg/h (13.6 lbs/h)
1.6 mm (1/16 in.)	385 A	31 V	1016 cm/min (400 in./min)	84 %	6.4 kg/h (14.1 lbs/h)
1.4 mm (.052 in.)	250 A	34 V	762 cm/min (300 in./min)	80 %	3.4 kg/h (7.4 lbs/h)
1.6 mm (1/16 in.)	325 A	30 V	762 cm/min (300 in./min)	85 %	4.8 kg/h (10.6 lbs/h)
2.4 mm (3/32 in.)	410 A	29 V	635 cm/min (250 in./min)	86 %	9.6 kg/h (21.1 lbs/h)
1.4 mm (.052 in.)	300 A	35 V	1016 cm/min (400 in./min)	84 %	4.7 kg/h (10.3 lbs/h)
2.0 mm (5/64 in.)	200 A	27 V	381 cm/min (150 in./min)	83 %	3.6 kg/h (8.0 lbs/h)
2.4 mm (3/32 in.)	350 A	28 V	508 cm/min (200 in./min)	86 %	7.6 kg/h (16.9 lbs/h)
1.4 mm (.052 in.)	390 A	35 V	1524 cm/min (600 in./min)	86 %	7.3 kg/h (16.1 lbs/h)
1.4 mm (.052 in.)	340 A	36 V	1270 cm/min (500 in./min)	85 %	6.1 kg/h (13.4 lbs/h)

Recommended Welding Parameters

Current	Wire Diameter	TTW Dist.	Voltage	Wire Feed Speed
100% CO ₂				

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Current	Wire Diameter	TTW Dist.	Voltage	Wire Feed Speed
135-205 A	1.2 mm (.045 in.)	9.5-12.7 mm (3/8-1/2 in.)	23-26 V	381-660 cm/min (150-260 in./min)
165-270 A	1.6 mm (1/16 in.)	16-19 mm (5/8-3/4 in.)	25-28 V	279-508 cm/min (110-200 in./min)
235-290 A	1.4 mm (.052 in.)	16-19 mm (5/8-3/4 in.)	25-29 V	584-864 cm/min (230-340 in./min)
345-415 A	1.6 mm (1/16 in.)	25.4-31.75 mm (1-1.25 in.)	28-32 V	762-1067 cm/min (300-420 in./min)
230-265 A	1.2 mm (.045 in.)	19-25.4 mm (3/4-1 in.)	26-30 V	965-1321 cm/min (380-520 in./min)
205-230 A	1.2 mm (.045 in.)	12.7-19 mm (1/2-3/4 in.)	25-27 V	660-965 cm/min (260-380 in./min)
235-500 A	2.4 mm (3/32 in.)	25.4-31.75 mm (1-1.25 in.)	27-30 V	178-508 cm/min (70-200 in./min)
125-235 A	1.4 mm (.052 in.)	12.7-16 mm (1/2-5/8 in.)	23-26 V	279-584 cm/min (110-230 in./min)
285-375 A	2.0 mm (5/64 in.)	19-25.4 mm (3/4-1 in.)	27-31 V	317.5-508 cm/min (125-200 in./min)
290-350 A	1.4 mm (.052 in.)	19-25.4 mm (3/4-1 in.)	29-31 V	864-1194 cm/min (340-470 in./min)
270-345 A	1.6 mm (1/16 in.)	19-25.4 mm (3/4-1 in.)	27-30 V	508-762 cm/min (200-300 in./min)
375-475 A	2.0 mm (5/64 in.)	25.4-31.75 mm (1-1.25 in.)	28-32 V	508-762 cm/min (200-300 in./min)
500-630 A	2.4 mm (3/32 in.)	31.75-38 mm (1.25-1.5 in.)	30-34 V	508-698.5 cm/min (200-275 in./min)