Dual Shield 700X

Dual Shield 700X is a high deposition, deep penetration wire for joining of heavy structural steel components. Designed for flat and horizontal position welding using CO2 shielding gas, this X Series wire provides high deposition rates, high efficiency and excellent performance. The bead contour, smooth ripple and slag chemistry allow easy slag removal even in narrow groves.

Specifications	
Classifications	AWS A5.20 : E70T-1CH8/T-9CH8
Approvals	A.B.S.- 2SA,2YSA ASME SFA 5.20 AWS A5.20 : E70T-1CH8/T-9CH8 CERTIFIED BY C.W.B.- CSA W48 DNV III YMS L.R. - 3S,3YS
Industry	Heavy Equipment Large Components Mobile Equipment Agricultural Equipment

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

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
100% CO2			
As Welded	545 MPa	600 MPa	29 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
100% CO2		
As Welded	-18 °C	66 J
As Welded	-29 °C	45 J

Typical Weld Metal Analysis %		
C	**S**	**P**
100% CO2		
0.035	0.015	0.011

Deposition Data						
Diameter	**Amps**	**Volts**	**Wire Feed Speed**	**Efficiency (Per)**	**TTW Dist**	**Deposition Rate**
100% CO2						
1.6 mm	205 A	25 V	406 cm/min	80 %	19 mm	2.2 kg/h
1.6 mm	187 A	24 V	356 cm/min	80 %	19 mm	1.9 kg/h
2.4 mm	350 A	28 V	508 cm/min	86.3 %	25.4 mm	7.7 kg/h
1.6 mm	149 A	23 V	254 cm/min	80 %	19 mm	1.3 kg/h
1.6 mm	223 A	25 V	457 cm/min	80 %	19 mm	2.5 kg/h
2.4 mm	290 A	27 V	381 cm/min	86.9 %	25.4 mm	5.8 kg/h
2.4 mm	475 A	32 V	762 cm/min	84.8 %	25.4 mm	11.3 kg/h
1.6 mm	289 A	26 V	660 cm/min	81 %	19 mm	3.8 kg/h
1.6 mm	273 A	26 V	610 cm/min	81 %	19 mm	3.5 kg/h
1.6 mm	240 A	25 V	508 cm/min	80 %	19 mm	2.9 kg/h
2.4 mm	410 A	29 V	635 cm/min	86 %	25.4 mm	9.6 kg/h
1.6 mm	257 A	26 V	559 cm/min	81 %	19 mm	3.2 kg/h
1.6 mm	168 A	24 V	305 cm/min	80 %	19 mm	1.6 kg/h

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Welding_Parameters				
Amps	**Wire Diameter**	**TTW Dist**	**Volts**	**Wire Feed Speed**
100% CO2				
290-610 A	2.4 mm	25.4-38 mm	26-34 V	254-825.5 mm/min
180-460 A	1.6 mm	19-25.4 mm	25-34 V	343-1270 mm/min