

PRIMACORE® LW-70MC

TYPICAL APPLICATIONS

PRIMACORE® LW-70MC is a CO₂ shielded, metal cored welding wire designed for welding of mild steel in applications requiring high deposition rate and travel speed. PRIMACORE® LW-70MC provides excellent bead appearance, very low spatter, good impact property and resistance to porosity on primed or scaly plate.

TOP FEATURES

- Robust impact values@-30 C
- Superior product consistency with optimal alloy control
- Very low spatter,fast travel speed and no slag
- High resistance to porosity on primed or scaly plate
- Manufactured under a quality system certified to ISO 9001-2015 requirements

SHIELDING GAS

- 100%CO₂ shielding gas

CONFORMANCE

- AWS A5.18/ ASME SFA-5.18: E70C-6C
- (with 100% CO₂ shielding gas only)
- AWS A5.36 E70T15-C1A2-CS1
- JIS Z3313: T493T15-0CA-H10

PACKAGING TYPE

- All spools of wire are level layer wound on black plastic spools.
- The spools are vacuum-packed with silica gel packets in moisture proof, foil-poly bags.
- The spools of wire are boxed and securely stacked on wooden pallets with shrink-wrap plastic.

WELDING POSITIONS



TYPICAL APPLICATIONS

PRIMACORE®LW-70MC is designed for use in high efficient welding of 490N/mm² tensile steels especially in down hand welding position. It is suitable for shipbuilding and steel structure fabrication.

DIAMETERS / PACKAGING

Diameter(mm)	Spool/Drum Weight(kg)	Pallet Weight(kg)
1.2	15kg/Spool	1080
1.4	15kg/Spool	1080
1.6	15kg/Spool	1080
1.2	225kg Bulk Drum	900
1.4	200kg Bulk Drum	800
1.6	200kg Bulk Drum	800
1.4	350kg Bulk Drum	800
1.6	350kg Bulk Drum	800

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Chemical Composition

	C%	Si%	Mn %	S %	P%	Ni%	Cr%	Mo%	V%	Cu%
AWS:E70C-6C Requirements	0.12	0.90	1.75	0.03	0.03	0.50	0.20	0.30	0.08	0.50
Typical Values (With 100%CO ₂)	0.05	0.55	1.52	0.02	0.01	0.01	0.01	0.00	0.00	0.02

* Test results and product properties listed herein for gas shielded wires have been developed with the shielding gas stated. A change of shielding gas may cause significant changes in product performance and weld metal properties. Lincoln Electric does not cover these products under warranty for use with shielding gases other than those listed in the test data.

Mechanical Properties

	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	CVN Impact(J@-30 C)
AWS:E70C-6C Requirements	min440	min480	min22	min27
Typical Values (With 100%CO ₂)	410	510	30	64

TYPICAL OPERATING PROCEDURES

Diameter Polarity ESO mm(inches)	Voltage (V)	Approx.Current (A)
1.2mm	16-19	130-160
	DC+	25-29
20[3/4]	30-38	280-360
	DC+	26-28
1.6mm	30-32	260-340
	DC+	34-38
20[3/4]		320-420

Customer Assistance Policy

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customers particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has not been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to change - This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com.cn for any updated information.

Authorized Distributor:

The product performance data of this brochure and related attachments are from LINCOLN ELECTRIC application engineering laboratory. Except for special instructions, experiments on welding machines are conducted in accordance with the general standard of IEC60974-1; experiments on welding consumables are conducted in accordance with the general standard of AWS; for specific applicable standards on welding consumables please refer to the product page. The product performance data of this website and related attachments are from LINCOLN ELECTRIC American application engineering laboratory.

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