

PRIMACORE® MW-70MC

TYPICAL APPLICATIONS

PRIMACORE® MW-70MC is designed for use in high efficient welding of 490N/mm² tensile steels especially in down hand welding position. It is suitable for many industries, such as heavy fabrication, shipbuilding and structural steel fabrication.

ADVANTAGE

- 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 mill scaled plate.
- Manufactured under a quality system certified to ISO 9001-2008 requirements

PACKAGING TYPE

- All spools of wire are level layer wound on plastic spools.
- The spools are vacuum-packed in moisture proof, foil-poly bags.
- The spools of wire are boxed and securely stacked on wooden pallets with plastic shrink-wrap.
- 300 and 300kg foil lined drums
- Providing excellent moisture resistance

CONFORMANCE

- AWS A5.18/ ASME SFA-5.18: E70C-6M
- AWS A5.36 E70T15-M21A2-CS1
- JIS Z3313:T493T15-0MA-H10

WELDING POSITIONS



SHIELDING GAS

- Ar+5-25% CO₂ shielding gas

APPROVALS

- JIS

DIAMETERS / PACKAGING

Diameter(mm)	Spool/Drum Weight(kg)	Pallet Weight(kg)
1.2	15	1080
1.2	300	600
1.4	15	1080
1.4	350	700
1.6	15	1080
1.6	350	700

Chemical Composition

	C%	Mn%	Si%	S%	P%
Requirements AWS Max	0.12	1.75	0.90	0.03	0.03
Typical Value	0.06	1.58	0.61	0.02	0.01

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Mechanical Properties

	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	CVN Impact(J@-30 C)
Requirements AWS	Min. 400	Min. 480	Min. 22	Min. 27
Typical Value	455	565	31.5	70

TYPICAL OPERATING PROCEDURES

Diameter Polarity ESO(mm)	Wire Feed Speed (m/min)	Voltage (V)	Approx. Current (A)	Deposition Rate (Kg/hr)
12mm DC+	5.1	21-23	170	2.3
	6.4	22-25	190	2.7
	7.6	22-26	210	3.2
	8.9	22-27	245	3.9
	10.2	23-27	265	4.5
	12.7	23-28	300	5.6
	15.2	25-29	335	6.9
19mm	17.8	26-30	370	7.9
	2.5	21-24	175	2.0
	3.8	22-25	235	2.9
	5.1	22-26	290	4.0
	6.4	22-28	345	5.2
	7.6	23-29	360	6.3
	10.2	26-31	425	8.4
12.7	27-32	485	10.7	

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.

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