DESCRIPTION:
AFL-X70-O is a self-shielded low-alloy flux cored wire designed for 490N/mm² grade steel, low temperature high tensile steel. Electrical polarity choice is DC(-), droplet mode is spray transfer.

APPLICATIONS:
Deposited metal has excellent impact properties and crack resistance, can be used in API Gr. X70 steel pipe welding, and low-alloy steel welding.

NOTE ON USAGE:
1. Use DC (-) polarity.
2. Clean up the base metal free from contamination.
3. Take proper wind-proof procedure while welding to avoid the blow holes.
4. Keep the inter-pass temperature below 150°C

WELDING POSITION:

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%):(Shielding Gas: 100% CO2)
Weld Metal Analysis :
Carbon (C)  0.06
Manganese (Mn)  1.13
Silicon (Si)  0.12
Aluminum (Al)  1.14
Nickel (Ni)  0.82
Sulphur (S)  0.004
Phosphorus (P)  0.011

TYPICAL MECHANICAL PROPERTIES OF WELD METAL:(Shielding Gas: 100% CO2)
YP N/mm²  424
TS N/mm²  523
EL %  28
IV J (-40°C)  120

APPROVALS:
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SUGGESTED WELDING PARAMETERS (DC <->)

<table>
<thead>
<tr>
<th>Parameters</th>
<th>Diameter (mm)</th>
<th>1.6mm</th>
<th>2.0mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>Voltage (Volt)</td>
<td>16 ~ 20</td>
<td>16 ~ 20</td>
<td></td>
</tr>
<tr>
<td>Current (Amp)</td>
<td>180 ~ 250</td>
<td>180 ~ 280</td>
<td></td>
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<tr>
<td>E.S.O.(mm)</td>
<td>10 ~ 20</td>
<td>10 ~ 20</td>
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