

Tru-Core® FC 70T Flux-Cored Welding Wire

AWS E70T-1C H8, E70T-9C H8



Tru-Core® FC 70T is a flux cored, gas-shielded electrode designed for single and multiple pass welding of carbon steels in the flat position and for horizontal fillets. It is suitable for welding most carbon steels requiring a minimum tensile strength of 70,000 psi.

This electrode is designed to operate with 100% carbon dioxide shielding gas. The rutile-based slag system promotes a smooth arc transfer and extremely easy slag removal.

100% Made in the U.S.A. with American steel to meet "Buy America" Standards.

Manufacturing Advantages

- Welding structural steel when the work is positioned where increased productivity and high deposition rates are a priority
- Patented forming, feeding, and drawing equipment
- Consistent strip-to-core ratio
- Precise thermal treatment that controls the type, amount, and uniformity of surface oxides on the wire
- Consistent diffusible hydrogen levels
- Consistent distribution of core ingredients
- Suitable for producing aesthetically pleasing and uniform weld beads

Welding Positions

Flat and horizontal position welding is possible when using the correct shielding gas blends, welding process, and welding parameters.

Shielding Gas Blends

- 100% CO₂
- 75-80% Argon + balance CO₂
- Flow rate: 35-45 CFH

Applications

- Agricultural Equipment
- General Fabrication
- Heavy Equipment
- Pipe Welding
- Pressure Vessels
- Structural Steel
- Trailers

Specifications

Meets or Exceeds:

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- AWS A5.20, ASME SFA-A5.20 E70T-(1M, 1C, 9M, 9C) H8
- AWS A5.36 E70T1-(C1A0, M21A0, C1A2, M21A)-CS1 H8
- CWB W48: E490T1-C1A3-CS1-H8 (E492T-9-H8)

✓ Made in the USA

Storage

Welding wire should be stored in a dry, enclosed environment and in its originally sealed package.



3602 North Perkins Road
Stillwater, OK 74075
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www.NSARC.com



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Typical Weld Metal Composition (as required per AWS)

		C	Mn	Si	P	S	Cu	Ni	Cr	Mo
FC 70T	100% CO ₂	0.06	1.6	0.67	0.013	0.01	0.09	0.35	0.05	0.01
	AWS/ASME	0.12 (max.)	1.75 (max.)	0.90 (max.)	0.03 (max.)	0.030 (max.)	0.35 (max.)	0.50 (max.)	0.20 (max.)	0.30 (max.)

Typical Mechanical Properties (as welded)

		TENSILE STRENGTH KSI	YIELD STRENGTH KSI	ELONGATION (% IN 2")	CVN @ -20° F (-29°C)
FC 70T	100% CO ₂	88.8	75.3	28	27.3 ft-lbf
	AWS/ASME	70-95	58 (min.)	22 (min.)	20 ft-lbf

Typical Diffusible Hydrogen (ml/100g)

FC 70T	100% CO ₂	7
	AWS A4.3	8.0 (max.)



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