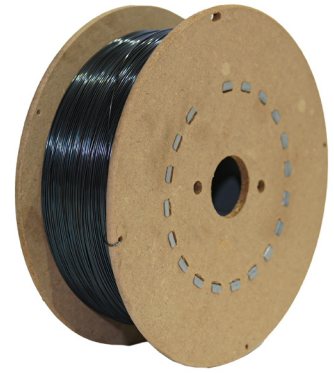


# Tru-Core® MC 70C Metal-Cored Welding Wire

**AWS E70C-6M H4, E70C-3M H4**



Tru-Core® MC 70C is a metal-cored, gas-shielded electrode intended for gas metal arc welding with shielding gas blends of 75-95% Argon, balance Carbon Dioxide.

It is designed to weld carbon steels and certain low-alloy steels in applications demanding higher productivity and requiring a minimum of 70,000 psi tensile strength. The core is comprised entirely of metallic powders, allowing the electrode to perform like a solid wire. It is recommended for use in single- and multiple-pass applications.

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

## Manufacturing Advantages

- Welding most carbon steels, such as ASTM A 36, A 285, A 515 Grade 70, and A 516 Grade 70, as well as certain low alloy steels
- Ideal for gauges ranging from heavier sheet metal to thick plate
- Ideal Manual, automatic, or robotic applications
- Suitable for producing aesthetically pleasing and uniform weld beads
- Higher deposition rates for increased productivity
- Suitable for welding low-alloy steels and different base metals

## Welding Positions

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

## Shielding Gas Blends

- 75-95% Argon/Balance CO<sub>2</sub>
- Flow rate: 35-45 CFH

## Applications

- Agricultural Equipment
- Auto Body
- Automotive Exhaust
- General Fabrication
- Heavy Equipment
- Pressure Vessels
- Shipbuilding
- Structural Steel
- Structures
- Railcars

## Specifications

Meets or Exceeds:

- AWS A5.18/A5.18M, ASME SFA-A5.18 E70C-3M H4, E70C-6M H4
- AWS A5.36 E70T15-M12P2-CS1 H4, E70T15-M20P2-CS1 H4, E70T15-M21P2-CS1 H4
- CWB W48: E490T15-M12A3-CS1-H4

✓ Made in America

## Storage

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



3602 North Perkins Road  
Stillwater, OK 74075  
Customer Service: 1-800-777-1618  
www.NSARC.com



# Tru-Core<sup>®</sup> MC 70C Metal-Cored Welding Wire

**AWS E70C-6MH4, E70C-3MH4**

## Typical Weld Metal Composition (as required per AWS)

	C	Mn	Si	P	S	Cu	Ni	Cr	Mo	V
75% Ar/25% CO <sub>2</sub>	0.04	1.6	0.82	0.009	0.01	0.06	0.02	0.05	0.01	0
90% Ar/10% CO <sub>2</sub>	0.04	1.61	0.85	0.006	0.009	0.05	0.02	0.04	0.001	<0.001
<b>AWS/ASME</b>	<b>0.12 (max.)</b>	<b>1.75 (max.)</b>	<b>0.90 (max.)</b>	<b>0.03 (max.)</b>	<b>0.03 (max.)</b>	<b>0.50 (max.)</b>	<b>0.50 (max.)</b>	<b>0.20 (max.)</b>	<b>0.30 (max.)</b>	<b>0.08 (max.)</b>

## Typical Mechanical Properties (as welded)

	TENSILE STRENGTH KSI	YIELD STRENGTH KSI	ELONGATION (% IN 2")	CVN @ -20° F (-29°C)
75% Ar/25% CO <sub>2</sub>	81.5	66.9	32	46.7 ft-lbf
90% Ar/10% CO <sub>2</sub>	83.9	70.8	30	32.6 ft-lbf
<b>AWS/ASME</b>	<b>70 (min.)</b>	<b>58 (min.)</b>	<b>22 (min.)</b>	<b>20 ft-lbf</b>

## Typical Diffusible Hydrogen (ml/100g)

75% Ar/25% CO <sub>2</sub>	1.1
90% Ar/10% CO <sub>2</sub>	2.06
<b>AWS/ASME</b>	<b>4.0 (max.)</b>



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