TECHNICAL DATA SHEET

parweld
WELDING THE FUTURE

XP 70-MC (Seamless)

MILD STEEL

CLASSIFICATIONS

EN ISO 17632-A	AWS A5.18
T 46 4 P M21 1 H5	E70C-6M H4

KEY FEATURES AND APPLICATIONS

- Seamless metal cored wire designed for welding carbon steels and low-alloyed steels.
- Provides excellent arc stability, bead appearance and penetration resulting in high-quality welds.
- Typical diffusible hydrogen content is <3.0 ml 100 g. Guaranteed for the total processing time <4.0 ml 100 g.
- Excellent mechanical properties at subfreezing temperatures down to -40°C.
- Widespread usage across diverse industries including pipeline projects, shipbuilding, non-alloy and fine-grain steel applications, pressure vessel fabrication, offshore structures, mechanical engineering, heavy transportation and various other industries.

BASE MATERIALS

S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M, P235GH-P355GH, P355N, P285NHP460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE240

ASTM A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C; A 414 Gr. A, B, C, D, E, F, G; A 501 Gr. B; A 516 Gr. 55, 65, 70; A573 Gr. 58, 65, 70; A 588 Gr. A, B; A 633 Gr. C; A 662 Gr. B; A 711 Gr. 1013; A 841 Gr. A; API 5 L Gr. B, X42, X52, X56, X60, X65

CHEMICAL COMPOSITION OF WIRE %

	C	Mn	Si	P	S	Cr	Ni	Mo	V	Nb	Cu
MIN	-	-	-	-	-	-	-	-	-	-	-
MAX	2.0	-	-	-	-	0.2	0.5	0.2	0.08	0.05	0.3

Single values are maximum values according to EN ISO 17632

MECHANICAL PROPERTIES OF ALL-WELD METAL - TYPICAL (MIN.) VALUES

Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Impact ISO-V (J)	Test Temperature
490 (≥460)	570 (530 - 680)	28 (≥20)	120 (≥47)	-40°C

Test data for mechanical properties are not guaranteed since actual as welded conditions depend on numerous variables

OPERATING DATA

Shielding Gases	Polarity
EN ISO 14175 - M21	DC+

WELDING PARAMETERS

Diameter (mm)	Current (A)	Voltage (V)
1.2mm	90 - 300	14 - 32

PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Spool	Weight (kg)	Pallet Qty
XP15421	1.2	BS300	16	64