

Supershield 7

Type : Self-Shielded

Conformances

AWS A5.36/ ASME SFA5.36 E70T7-AZ-CS3
 (AWS A5.20/ ASME SFA5.20 E70T-7)
 EN ISO 17632-A-T 46 Z Z W NO 3

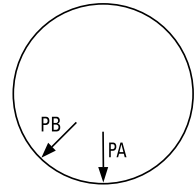
Applications

- general fabrication
- Heavy equipment
- Machinery

Features

- High deposition rate
- Easy slag removal
- Good crack resistance
- Good porosity resistance

Welding Position



Current

DC -

Shielding Gas

No shielding gas

Diameter / Packaging

Diameter	Spool	Coil
mm (in)	12.5kg (28lbs)	25kg (55lbs)
2.0 (0.078 in)	✓	✓
2.4 (0.094 in)		✓

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Al
0.26	0.17	0.25	0.011	0.005	1.54

Typical Mechanical Properties of All-Weld Metal

YS Mpa(lbs/in ²)	TS Mpa(lbs/in ²)	EL (%)
492 (71,400)	635 (92,100)	23

Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)	Efficiency (%)
2.0mm (0.078 in) DC-						
No shielding gas	40 (1.57)	3.9 (155)	250-280	23-27	3.5 (7.7)	78-82
		5.0 (200)	290-320	24-28	4.3 (9.4)	
No shielding gas	45 (1.77)	6.2 (245)	330-360	24-29	5.3 (11.6)	79-84
		2.4mm (0.094 in) DC-				
No shielding gas	45 (1.77)	3.3 (130)	270-300	23-26	4.4 (9.7)	79-84
		4.0 (160)	310-340	24-27	5.6 (12.3)	
		4.6 (185)	350-380	24-28	6.6 (14.5)	
		5.4 (215)	390-420	25-30	7.4 (16.3)	

SMW

SAW

GMW

GTAW

FCAW

Non-FERROUS

APPENDIX