

Premierweld™ IN70

AWS EA2



Premierweld™ IN70 is a low carbon, medium manganese, medium silicon submerged arc welding wire. It produces welds with excellent mechanical properties depending on the flux and procedures used. It is suited for single / multiple arc configurations as well as 2 Run & multi user technics. It is supplied in 650 Kg Drums

KEY FEATURES

- ▶ Consistent weld deposit chemistry and procedure from drum to drum improve quality and save time.
- ▶ Has no soft spots, set the welding procedure once and forget about them.
- ▶ Thin copper coating yields significantly improved electrical contact between wire and contact tip for better stability and longer tip life.
- ▶ Low feed force help to reduce wear and tear on equipment.
- ▶ Can be used with 761, 780, 781, 782, 8500, 888, P223, P230, 995N 998N Fluxes.

APPLICATIONS

- ▶ Stress relieved applications where 70,000psi tensile strength is required.
- ▶ Pipe mill applications

CONFORMANCE

AWS A5.23

EA2

DIAMETERS / PACKAGING

Diameter (mm)	Coils (Kg)	Drums (Kg)	Product No.
3.2	30	-	ICS70320
3.2	-	250	ICS70322
3.2	-	650	ICS70326
4.0	30	-	ICS70400
4.0	-	250	ICS70402
4.0	-	650	ICS70406

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TYPICAL CHEMICAL COMPOSITION, ELECTRODE

	%C	%Mn	%Si	%S	%P	%Mo
Requirements AWS A5.23 EA2	0.05 - 0.17	0.95 - 1.35	0.20 max	0.025 max	0.025 max	0.45 - 0.65
Typical Values	0.090	1.085	0.176	0.016	0.018	0.55

TYPICAL CHEMICAL COMPOSITION, ALL WELD METAL

	%C	%Mn	%Si	%S	%P	%Mo
Requirements A5.23 F8A2-EA2	-	-	-	-	-	-
Typical Values	0.074	1.320	0.415	0.007	0.016	0.504

MECHANICAL PROPERTIES, ALL WELD METAL

	Tensile Strength MPa	Yield Strength MPa	Elongation (%)	Charpy V-Notch J @ -29°C
Requirements A5.23 F8A2-EA2	550 - 688	468	20 min	27
Typical Values	650	592	27	67

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

CUSTOMER ASSISTANCE POLICY

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Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com for any updated information.

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