

Supershield 4

Type : Self-Shielded

Conformances

AWS A5.36/ ASME SFA5.36 E70T4-AZ-CS3
 (AWS A5.20/ ASME SFA5.20 E70T-4)
 EN ISO 17632-A-T 42 Z Z W NO 3

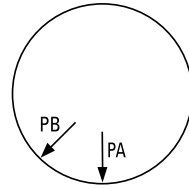
Applications

- Heavy equipment
- Machinery

Features

- High deposition rate
- 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
0.21	0.36	0.38	0.011	0.003	1.21

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)
450 (65,300)	580 (84,100)	24

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	50 (2)	5.1 (200)	260-300	29-31	1.6 (3.5)	81-84
		6.1 (240)	290-330	30-32	2.3 (5.1)	
		6.6 (260)	310-350	30-32	2.6 (5.7)	
		7.6 (300)	330-370	31-33	3.1 (6.8)	
2.4mm (0.094 in) DC+						
No shielding gas	76 (3)	2.8 (110)	230-270	28-30	2.0 (4.3)	80-85
		3.8 (150)	280-320	29-31	2.5 (5.5)	
		4.7 (185)	330-370	30-32	3.0 (6.6)	
		5.8 (230)	380-420	31-33	4.2 (9.2)	
		7.0 (275)	430-470	32-34	5.6 (12.3)	