

Spoolarc 65

Spoolarc 65 is a triple deoxidized (Aluminum, Titanium, Zirconium) welding wire designed for welding over rust and mill scale. The less fluid weld puddle of Spoolarc 65 makes it easy to control when used out of position. Spoolarc 65 is the preferred wire for all position welding of small diameter pipe. It is available in forms suitable for MIG and TIG welding.

Classifications	AWS A5.18 : ER70S-2 H4
Industry	Power Generation Military Applications Pipeline Ship/Barge Building

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
98% Ar - 2% O₂			
As Welded	480 MPa (70 ksi)	565 MPa (82 ksi)	26 %
100% Ar			
As Welded	460 MPa (67 ksi)	545 MPa (79 ksi)	26 %

Typical Charpy V-Notch Properties

Conditional Statement	Condition	Testing Temperature	Impact Value
98% Ar - 2% O₂			
GMAW	As Welded	-29 °C (-20 °F)	61 J (45 ft-lb)
100% Ar			
GMAW	As Welded	-29 °C (-20 °F)	47 J (35 ft-lb)

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Al
0.06	1.14	0.50	0.006	0.004	0.03	0.06	0.01	0.01	0.08

Typical Wire Composition %

Cu	Ti	Zr
0.10	0.10	0.04

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Type	Deposition Rate
0.9 mm (.035 in.)	180 A	25 V	1016 cm/min (400 in./min)	Spray Transfer	2.9 kg/h (6.3 lbs/h)
0.9 mm (.035 in.)	197 A	26 V	1143 cm/min (450 in./min)	Spray Transfer	3.2 kg/h (7.1 lbs/h)
0.9 mm (.035 in.)	213 A	26 V	1270 cm/min (500 in./min)	Spray Transfer	3.6 kg/h (7.9 lbs/h)
0.9 mm (.035 in.)	230 A	27 V	1397 cm/min (550 in./min)	Spray Transfer	4.0 kg/h (8.7 lbs/h)
1.2 mm (.045 in.)	260 A	25 V	762 cm/min (300 in./min)	Spray Transfer	3.6 kg/h (7.9 lbs/h)
1.2 mm (.045 in.)	280 A	26 V	889 cm/min (350 in./min)	Spray Transfer	4.2 kg/h (9.2 lbs/h)

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Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Type	Deposition Rate
1.2 mm (.045 in.)	300 A	28 V	1016 cm/min (400 in./min)	Spray Transfer	4.8 kg/h (10.5 lbs/h)
1.2 mm (.045 in.)	320 A	29 V	1143 cm/min (450 in./min)	Spray Transfer	5.4 kg/h (11.8 lbs/h)
1.2 mm (.045 in.)	340 A	30 V	1270 cm/min (500 in./min)	Spray Transfer	6.0 kg/h (13.1 lbs/h)
1.6 mm (1/16 in.)	290 A	26 V	457 cm/min (180 in./min)	Spray Transfer	4.1 kg/h (9.1 lbs/h)
1.6 mm (1/16 in.)	310 A	28 V	508 cm/min (200 in./min)	Spray Transfer	4.6 kg/h (10.1 lbs/h)
1.6 mm (1/16 in.)	340 A	31 V	584 cm/min (230 in./min)	Spray Transfer	5.3 kg/h (11.6 lbs/h)
1.6 mm (1/16 in.)	370 A	34 V	660 cm/min (260 in./min)	Spray Transfer	6.0 kg/h (13.2 lbs/h)
1.6 mm (1/16 in.)	390 A	36 V	711 cm/min (280 in./min)	Spray Transfer	6.4 kg/h (14.2 lbs/h)
0.9 mm (.035 in.)	90 A	15 V	457 cm/min (180 in./min)	Short Arc Transfer	1.2 kg/h (2.7 lbs/h)
0.9 mm (.035 in.)	113 A	16 V	559 cm/min (220 in./min)	Short Arc Transfer	1.5 kg/h (3.3 lbs/h)
0.9 mm (.035 in.)	137 A	18 V	660 cm/min (260 in./min)	Short Arc Transfer	1.8 kg/h (4.0 lbs/h)
0.9 mm (.035 in.)	160 A	19 V	762 cm/min (300 in./min)	Short Arc Transfer	2.1 kg/h (4.6 lbs/h)
1.2 mm (.045 in.)	130 A	17 V	318 cm/min (125 in./min)	Short Arc Transfer	1.4 kg/h (3.1 lbs/h)
1.2 mm (.045 in.)	163 A	18 V	406 cm/min (160 in./min)	Short Arc Transfer	1.8 kg/h (4.0 lbs/h)
1.2 mm (.045 in.)	200 A	19 V	508 cm/min (200 in./min)	Short Arc Transfer	2.3 kg/h (5.0 lbs/h)

Recommended Welding Parameters

Type	Current	Wire Diameter	Voltage	Wire Feed Speed
Short Arc Transfer	45-90 A	0.6 mm (.023 in.)	14-16 V	381-965 cm/min (150-380 in./min)
Short Arc Transfer	60-140 A	0.8 mm (.030 in.)	14-16 V	381-889 cm/min (150-350 in./min)
Short Arc Transfer	90-160 A	0.9 mm (.035 in.)	15-19 V	457-762 cm/min (180-300 in./min)
Short Arc Transfer	130-200 A	1.2 mm (.045 in.)	17-19 V	318-508 cm/min (125-200 in./min)
Short Arc Transfer	150-200 A	1.4 mm (.052 in.)	17-20 V	343-483 cm/min (135-190 in./min)
Spray Transfer	100-125 A	0.6 mm (.023 in.)	23-25 V	1016-1575 cm/min (400-620 in./min)
Spray Transfer	160-200 A	0.8 mm (.030 in.)	24-26 V	1270-1651 cm/min (500-650 in./min)

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Recommended Welding Parameters					
Type		Current	Wire Diameter	Voltage	Wire Feed Speed
Spray Transfer		180-230 A	0.9 mm (.035 in.)	25-27 V	1016-1397 cm/min (400-550 in./min)
Spray Transfer		260-340 A	1.2 mm (.045 in.)	25-30 V	762-1270 cm/min (300-500 in./min)
Spray Transfer		275-400 A	1.4 mm (.052 in.)	26-33 V	673-991 cm/min (265-390 in./min)
Spray Transfer		290-400 A	1.6 mm (1/16 in.)	26-36 V	457-711 cm/min (180-280 in./min)
Short Arc Transfer	Optimum	70 A	0.6 mm (.023 in.)	15 V	762 cm/min (300 in./min)
Short Arc Transfer	Optimum	100 A	0.8 mm (.030 in.)	15 V	559 cm/min (220 in./min)
Short Arc Transfer	Optimum	130 A	0.9 mm (.035 in.)	17 V	635 cm/min (250 in./min)
Short Arc Transfer	Optimum	160 A	1.2 mm (.045 in.)	18 V	381 cm/min (150 in./min)
Short Arc Transfer	Optimum	160 A	1.4 mm (.052 in.)	18 V	356 cm/min (140 in./min)
Spray Transfer	Optimum	110 A	0.6 mm (.023 in.)	23 V	1143 cm/min (450 in./min)
Spray Transfer	Optimum	180 A	0.8 mm (.030 in.)	25 V	1321 cm/min (520 in./min)
Spray Transfer	Optimum	200 A	0.9 mm (.035 in.)	26 V	1219 cm/min (480 in./min)
Spray Transfer	Optimum	300 A	1.2 mm (.045 in.)	27 V	889 cm/min (350 in./min)
Spray Transfer	Optimum	325 A	1.4 mm (.052 in.)	28 V	787 cm/min (310 in./min)
Spray Transfer	Optimum	340 A	1.6 mm (1/16 in.)	27 V	508 cm/min (200 in./min)