

Metal Cored Wire

Weld Process: Mig Welding Process

Alloy: Mild Steel Class: E70C-6M

Conforms to Certification: AWS A5.18 / ASME SFA 5.18

Alloy: DM70C-6M

TYPICAL APPLICATION:

Dura Max E70C-6M is designed for welding of 490MPa high tensile steel with only Ar/CO₂ gas mixtures. It is especially suitable for welding and has a high tolerance to primer.

Typical applications include machineries, shipbuilding, offshore structures, bridges and general fabrications.

CHARACTERISTICS ON USAGE:

- Wire is a metal type of flux cored wire for flat and horizontal position welding
- Slag quality is almost the same as solid wire and multiple pass welding can be performed without removing slag.
- 20% higher productivity can be achieved when compared to solid wires and it features good penetration, high resistance to porosity, good wetting behavior as well as low hydrogen contents.
- **E70C-6M** is intended for semi-automatic, automatic, single and multiple pass welding.

Typical Chemical Composition of all-weld metal (%)

	C	Si	Mn	P	S
AWS	≤ 0.12	≤ 0.90	≤ 1.75	≤ 0.03	≤ 0.03
Typical Values (M21)	0.04	0.80	1.50	0.014	0.013

All Weld Metal Mechanical properties (Typical)

	YS (Mpa)	UTS (Mpa)	EL %	CHARPY "V" NOTCH IMPACT AT (-30°C)
AWS	≥ 390	490 - 670	≥ 22	≥ 27
Typical Values (M21)	540	610	27	75

Sizes available and recommended currents (DC wire +)

Diameter		0.045	0.052	1/16
Current (AMP)	Flat(PA/1G)	140 – 300	160 – 380	180 – 400
	H-Fillet(PB/2F)	160 – 300	180 – 360	220 – 380

Approvals

Shielding Gas
M21