

## Flux Cored Wire

Weld Process: Mig Welding Process

Alloy: Mild Steel Class: E70T-XX

Conforms to Certification: AWS A5.20 / ASME SFA 5.20

Alloy: DM70T

### TYPICAL APPLICATION:

**Dura Max E70T-1** is designed for welding of 490MPa high tensile steel with outstanding mechanical properties. Typical applications include machineries, shipbuilding, offshore structures bridges and general fabrications.

### CHARACTERISTICS ON USAGE:

- 1- Wire is a metal type of flux cored wire for flat and horizontal position welding.
- 2- It has better excellent deposition rate when compared to conventional DM71T wire.
- 3- It also provides smooth arc, low spatter levels, beautiful bead appearance.
- 4- The shielding gas should be used 100%CO<sub>2</sub> or 75% Ar+25%CO<sub>2</sub> for welding

### Typical Chemical Composition of all-weld metal (%)

C	Mn	Si	P	S	Cr	Ni	Mo	V	Cu
0.12 max	1.75 max	0.90 max	0.03 max	0.03 max	0.20 max	0.50 max	0.30 max	0.08 max	0.35 max

### All Weld Metal Mechanical properties (Typical)

	YS (Mpa)	UTS (Mpa)	EL %	CHARPY "V" NOTCH IMPACT (J) @ -18°C
<b>AWS</b>	390 Min	490 - 670	22 Min	27 Min
<b>Typical Values</b>	547	603	29	56 (J)

### Sizes available and recommended currents (DC wire +)

Diameter	0.045	0.052	1/16
Polarity	DC +	DC +	DC +
Shielding Gas Used	75% Ar+25%CO <sub>2</sub>	75% Ar+25%CO <sub>2</sub>	75% Ar+25%CO <sub>2</sub>
Voltage (V)	25 - 32	24 - 32	24 - 32
Current (A)	180 - 280	160 - 340	180 - 380