DURAMAX™
Inspiring the future generations of welders

PRODUCT DATA SHEET

DM70S-2 Premium Welding Wire

Classification: **ER70S-2**

AWS A 5.18 / ASME SFA 5.18

DuraMax DM70S-2 is a triple deoxidized bare wire for GMAW and GTAW welding

Characteristics

DuraMax DM70S-2 is a premium wire for for welding on all grades of mild and carbon steels, producing quality welds with minimal porosity. It is triple deoxidized with small amounts of Zirconium, Titanium and Aluminum (Zr, Ti, Al) which makes it an excellent choice for welding over rust and mill scale.

Typical Applications on Usage

1) Pipes and Offshore drilling rigs.
2) Structural steel, carbon steel plate, fittings, castings and forgings....

All Weld Chemical Composition (%)

C =	0.07 max	Mn =	0.90 - 1.40	Si =	0.40 - 0.70	P =	0.025 max
S =	0.035 max	Ni =	0.15 max	Cr =	0.15 max	Mo =	0.15 max
V =	0.03 max	Cu =	0.50 max	Ti =	0.05 - 0.15	Zr =	0.02 - 0.12
Al =	0.05 - 0.15						

All Weld Mechanical Properties

Tensile Strength MPa	Yield Strength MPa	Elongation (%)	CHARPY "V" NOTCH IMPACT AT
480 min	400 min	22 min	Minus -30°C : ≥ 27 (J)

Sizes Available and Recommended Welding Parameters

Process	Diameter	Amperage	Voltage	Gas/Flux
GTAW	.035	50 - 70	10 - 12	100% Argon
	.045	70 - 100	10 - 12	
	1/16	100 - 125	12 - 15	
	3/32	125 - 175	15 - 20	
	1/8	175 - 250	15 - 20	
	5/32	175 - 250	15 - 20	
GMAW Short Arc	.035	90 - 160	14 - 20	100% CO_2 or 75% Ar + 25% CO_2 80% Ar + 20% CO_2
	.045	120 - 180	16 - 22	
	1/16	160 - 200	16 - 22	
GMAW Spray Transfer	.035	165 - 200	25 - 28	98% Ar + 2% O_2
	.045	180 - 220	25 - 30	75% Ar + 25% CO_2
	1/16	230 - 260	26 - 36	75% Ar + 25% CO_2