DURAMAX™
Inspiring the future generations of welders

PRODUCT DATA SHEET

DM70S-6 Premium Welding Wire

Classification: **ER70S-6**

AWS A 5.18 / ASME SFA 5.18

DuraMax DM70S-6 is a deoxidized bare wire for GMAW and GTAW welding

Characteristics

DuraMax DM70S-6 is is a mild steel welding wire that contains higher levels of manganese and silicon than other standard grades of wire. It produces a high quality weld when used on dirty, oily or rusty steels. The higher silicon content increases the fluidity of the weld pool, which gives a smoother bead appearance and results in minimal post weld grinding.

Typical Applications on Usage

1) General shop application & ornamental iron fabrication, construction
2) Tanks, steel castings

All Weld Chemical Composition (%)

C =	0.06 to 0.15	Mn =	1.40 - 1.85	Si =	0.80 - 1.15	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				

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	100 - 140	22 - 25	100% CO_2 or 75% Ar + 25% CO_2 80% Ar + 20% CO_2
	.045	120 - 150	23 - 26	
	1/16	160 - 200	23 - 26	
GMAW Spray Transfer	.035	165 - 200	28 - 32	98% Ar + 2% O_2
	.045	180 - 220	30 - 34	75% Ar + 25% CO_2
	1/16	230 - 260	30 - 34	75% Ar + 25% CO_2