

## DM70C-6M Metal Cored Wire

**Classification:** AWS A5.18 / ASME SFA 5.18

### TYPICAL APPLICATION:

DuraMax E70C-6M is designed for welding of 490MPa high tensile steel with only Ar/CO<sub>2</sub> 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 (%) (AWS)

C	Si	Mn	P	S
≤ 0.12	≤ 0.90	≤ 1.75	≤ 0.03	≤ 0.03

### Typical Chemical Composition of all-weld metal (%) (M21)

C	Si	Mn	P	S
0.04	0.80	1.50	0.014	0.013

### All Weld Metal Mechanical properties (Typical) (AWS)

Tensile Strength	Yield Strength	Elongation (%)	Hardness	Ferrite WRC (FN)	CVN Impacts (X)
					@ -30 °C
490 - 670 Mpa	≥ 390 Mpa	~ 22%	-----	~ 10	~ 10

### All Weld Metal Mechanical properties (Typical) (M21)

Tensile Strength	Yield Strength	Elongation (%)	Hardness	Ferrite WRC (FN)	CVN Impacts (X)
					@ -30 °C
~ 490	~ 390	~ 22%	-----	~ 10	~ 10

### Typical Welding Parameters DCEP or AC

Diameter		1/8"	3/16"	1/4"
Current (AMP)	Flat(PA/1G)	140 - 300	160 - 380	180 - 400
	H-Fillet(PB/2F)	160 - 300	180 - 360	220 - 380

### Approvals: Shield Gas (M21)