DURAMAX®
Inspiring the future generations of welders

Product Data Sheet

DM70T-1 Flux Cored Wire

Classification: **E70T-XX**
AWS A5.20 / ASME SFA 5.20

CHARACTERISTICS, FEATURES & APPLICATIONS

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%CO2 or 75% Ar+25%CO2 for welding

Typical Chemical Composition (%)

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

Typical Mechanical Properties as Welded

	Tensile Strength	Yield Strength	Elongation (%)	Hardness	Ferrite WRC (FN)	CVN Impacts (J) @ -18 °C
AWS	490 - 670	390 Min	22 Min	-------	-------	27 Min
Typical Values	603	547	29	-------	-------	56 (J)

Diameter	Polarity	Shielding Gas Used	Voltage (V)	Current (A)
0.045	DC+	75% Ar + 25% CO2	25–32	180–280
0.052	DC+	75% Ar + 25% CO2	24–32	160–340
1/16	DC+	75% Ar + 25% CO2	24–32	180–380

For additional information please visit our website at Duramax-weld.com or email info@duramax-weld.com

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