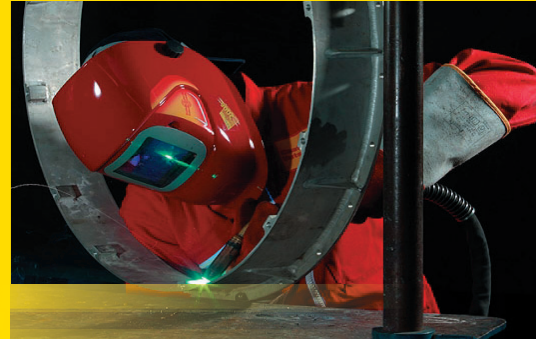


High Performance Seamless, Metal-Cored, Joining Wire

# EnD0tec® D0\*254



## WIRES

*The Ultimate Welding Solution For Your Joining Applications*

- Tensile strength exceeds 80,000 psi (550 mPa)
- Excellent low-temperature impact toughness
- Very low spatter loss
- Excellent bead appearance



## DESCRIPTION:

EnDOTec DO\*254 is a seamless, nickel alloyed, metal-cored wire for single or multi-pass fabrication of carbon and high strength steels.

EnDOTec DO\*254 wire provides very user friendly weldability in all positions with high deposition efficiency, excellent bead appearance, low spatter loss, and exceptional low-temperature mechanical properties.

## APPLICATIONS:

- Ship building
- Earth moving equipment
- Weathering steels
- Off shore structures
- Pipe work
- Bridges
- Railcars

## TECHNICAL DATA:

Specifications: A5.36 E80T15-M21A8-Ni1-H4

### Typical Mechanical Values:

Tensile Strength: 89.9 ksi (620 MPa)

Yield Strength: 76.8 ksi (530 MPa)

Elongation: 27%

Charpy V-notch Impact: 66 ft.-lbs. (90 J) at -76°F (-60°C)

## TYPICAL WELDING PARAMETERS:

DIAMETER	AMPERAGE	VOLTS	STICK-OUT	RUN	SHIELDING GAS*	FLOW RATE
0.045"	130-180	17-21	5/8"	Root	90%Ar-10%CO <sub>2</sub>	35 cfh
0.045"	140-320	17-31	5/8"	fill	90%Ar-10%CO <sub>2</sub>	35 cfh
1/16"	210-400	24-33	¾"	fill	90%Ar-10%CO <sub>2</sub>	35 cfh

\*75%Ar-25%CO<sub>2</sub> may also be used.

## YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



**EUTECTIC CORPORATION**  
N94 W14355 Garwin Mace Drive  
Menomonee Falls, WI 53051 USA  
Tel.: +1 (800) 558-8524  
eutectic.com

**EUTECTIC CANADA**  
428, rue Aimé-Vincent  
Vaudreuil-Dorion, Québec  
J7V 5V5 Canada  
Tel.: +1 (800) 361-9439  
eutectic.ca



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