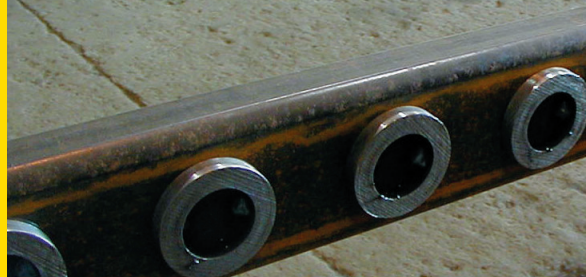


High Performance Seamless Cored Wire for Structural Steel Fabrication

EnDotec® DO*266S



WIRE

The Ultimate Welding Solution For Your Joining Applications

- Seamless, rutile cored wire
- Enhanced arc stability and less spatter
- Low heat input, low fume emission and all position welding
- Low hydrogen content
- Exceptional mechanical properties at low temperatures
- Superior wire feeding characteristics and low contact tip wear



DESCRIPTION:

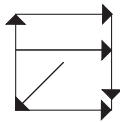
EnDOTec DO*266S is a seamless, rutile flux-cored wire for high quality structural steel fabrication. The wire provides very user-friendly weldability in all positions, and can be used for single or multi-pass fabrications. The weld deposits exhibit an easily removed slag, low spatter loss, smooth bead, and have excellent mechanical properties.

The advantages of seamless-cored wires are reduced contact tip wear, constant wire positioning accuracy, reduced wire feeding force, and no moisture pickup.

TECHNICAL DATA:

Specifications: AWS A5.36 E71T1-C1A2-CS1-H4,
E71T1-M21A4-CS1-H8

Polarity: DCEP (DC+)



APPLICATIONS:

- Shipbuilding
- Rolling Stock
- Earth Moving Equipment
- Mining Equipment
- Steels to API- Standards
- Boiler Steels
- Unalloyed Structural Steels
- Fine Grain Steels
- Pressure Vessels
- Pipe Work
- Off Shore Structures

TYPICAL MECHANICAL PROPERTIES:

SHIELDING GAS	TENSILE STRENGTH KSI (MPA)	YIELD STRENGTH KSI (MPA)	ELONGATION %	CHARPY V-NOTCH -4°F(-20°C)
75% Ar/25% CO ₂	84.1 (580)	72.5 (500)	26	96 ft•lbf (130 J)
100% CO ₂	79.8 (550)	69.6 (480)	25	81 ft•lbf (110 J)

TYPICAL WELDING PARAMETERS:

DIAMETER	AMPS	VOLTS*	STICK-OUT	RUN	SHIELDING GAS	FLOW RATE
0.045"	140-190	18-23	5/8"	Root	75% Ar/25% CO ₂	30-42 scfh
0.045"	200-320	21-31	5/8"	Fill	75% Ar/25% CO ₂	30-42 scfh
1/16"	210-400	24-33	3/4"	Fill	75% Ar/25% CO ₂	30-42 scfh

*Add 1.5-2 volts for 100% CO₂

YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



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