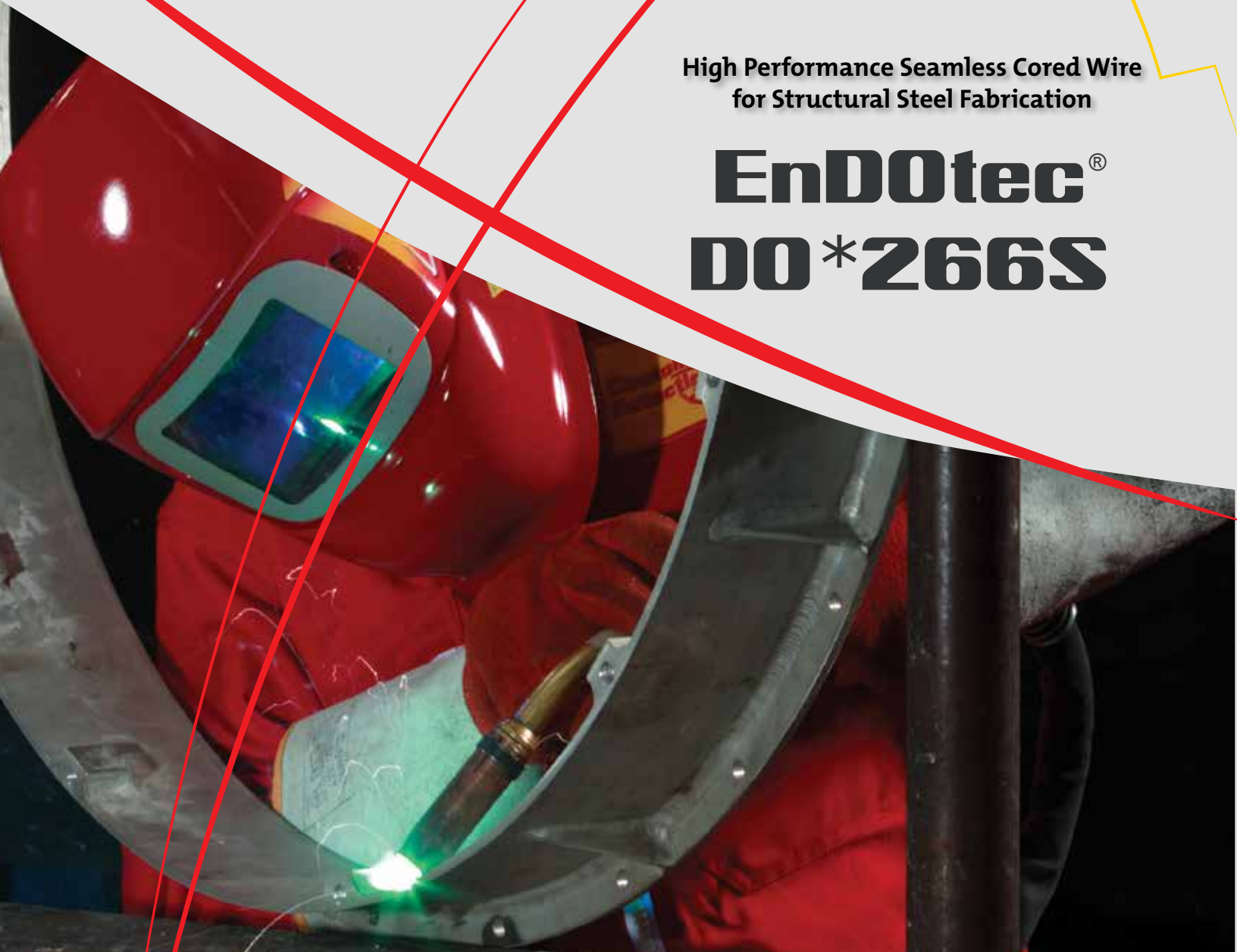




High Performance Seamless Cored Wire
for Structural Steel Fabrication

EnD0tec[®]

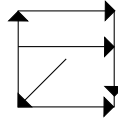
D0*266S



- Excellent weldability in all positions
- Enhanced arc stability and less spatter
- Low heat input, low fume emission
- Low hydrogen content
- Exceptional mechanical properties at low temperatures
- Superior wire feeding characteristics and low contact tip wear

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.



Typical Values	Shielding Gas	
	M21 (Ar + 18% CO ₂)	100% CO ₂
Tensile Strength KSI (MPA)	84.1 (580)	79.8 (550)
Yield Strength KSI (MPA)	72.5 (500)	69.6 (480)
Elongation %	26	25
Charpy V-Notch KV -4°F (-20°C)	96 ft•lbf (130 J)	81 ft•lbf (110 J)
Current Polarity:	DCEP (+)	

DIAMETER	AMPS	VOLTS*	STICK-OUT	RUN	SHIELDING GAS	FLOW RATE
0.045" (1.2mm)	140-190	18-23	5/8"	Root	75% Ar/25% CO ₂	30-42 scfh
0.045" (1.2mm)	200-320	21-31	5/8"	Fill		
1/16" (1.6mm)	210-400	24-33	3/4"	Fill		

*Add 1.5-2 volts for 100% CO₂

Specifications: AWS A5.36:
E71T1-C1A4-CS1-H4,
E71T1-M21A4-CS1-H4

Certified by the CWB to CSA W48-14:
E491T1-C1A4-CS1-H4 (CO₂)
E491T1-M21A4-CS1-H4 (M21: Ar + CO₂)

PROCEDURE FOR USE

Observe normal welding practices, respiratory protection and proper air flow pattern advised. For general welding practices, see AWS publications Z49.1 "Safety in Welding and Cutting and Allied Process". Welding is a completely safe process when performed in accordance with proper safety measures. Become familiar with local safety regulations before beginning welding operations. DO NOT operate welding equipment or use welding materials before you have thoroughly read the proper instruction manual(s). Please refer to the Eutectic internet site for Safety Data Sheet (SDS) information.

DISREGARDING THESE INSTRUCTIONS, AND/OR THE INSTRUCTIONS OF WELDING EQUIPMENT OR MATERIAL MANUALS, MAY BE HAZARDOUS TO YOUR HEALTH.

TYPICAL 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

