



High Performance Seamless Cored Wire  
for Joining Applications

**EnD0tec®**  
**DO\*267**

- Enhanced arc stability and less spatter
- Low heat input, low fume emission
- High yield alloy
- Especially suitable for automated applications

# EnDotec® DO\*267

High Performance seamless metal cored wire for single or multipass welding of carbon, carbon manganese and similar types, including fine grained steels with Ar-CO<sub>2</sub> shielding gas or pure CO<sub>2</sub>.

## Main Features:

High yield, good weldability, excellent bead appearance, no spatter or slag and exceptional mechanical properties at low temperatures (-40°F; -40°C). This wire is especially suitable for automated and robotized applications.

## TECHNICAL DATA

Typical Values	
Tensile Strength:	94,000 psi (648 MPa)
Yield Strength:	66,700 psi (460 MPa)
Elongation:	24%
Charpy V-Notch KV -40°F (-40°C)	> 47J (≈80J)
Current Polarity:	DCEP (+)

DIAMETER	AMPS	VOLTS	SHIELDING GAS	FLOW RATE
0.045" (1.2mm)	50-320	12-35	CO <sub>2</sub> or Ar - CO <sub>2</sub>	14-20 l/min
1/16" (1.6mm)	60-390	16-37		30-42 scfh

Specifications: AWS/ASME A5.36:  
70T15-C1A4-CS1-H4  
70T15-M20A4-CS1-H4

Certified by the CWB to CSA W48-14:  
E491T15-C1A4-CS1-H4 (CO<sub>2</sub>)  
E491T15-M20A4-CS1-H4 (M20: Ar / CO<sub>2</sub>)

## 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.

- Shipbuilding
- Rolling Stock
- High Temperature Pressure Vessels
- Heavy Duty Mining Equipment
- Ground Breaking Assemblies

## TYPICAL APPLICATIONS



Eutectic Corporation:  
N94 W14355 Garwin Mace Dr.  
Menomonee Falls WI, 53051 USA  
+1 800. 558. 8524 • eutectic.com

Eutectic Canada:  
428, rue Aimé-Vincent, Vaudreuil-Dorion,  
Québec J7V 5V5 Canada  
+1 800. 361. 9439 • eutectic.ca



Follow Us On...

