



High Performance Seamless Cored Wire
for Joining Applications

EnD0tec[®]

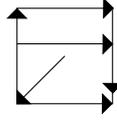
DO*271S

- Excellent weldability in all positions
- Enhanced arc stability and less spatter
- Low heat input, low fume emission
- Higher strength 1% nickel alloy
- Fast freezing, easy to remove slag

EnDotec® DO*271S

EnDotec® DO*271S is a high performance all position nickel alloyed seamless flux cored wire for single or multipass welding of carbon, carbon-manganese and high strength steels with Ar/CO₂ shielding gas or pure CO₂.

Excellent weldability in all positions, excellent bead appearance, no spatter; fast freezing and easy to remove slag. The exceptional mechanical properties of this wire, even at the lowest temperatures (-50°C; -58°F), make it especially suitable for off-shore applications.



TECHNICAL DATA

Typical Values	
Tensile Strength:	95,000 psi (655 MPa)
Yield Strength:	72,500 psi (500 MPa)
Elongation:	25%
Charpy V-Notch:	Ar/CO ₂ : KV (-50°C) > 47J (≈80J) CO ₂ : KV (-50°C) > 47J (≈60J)
Current Polarity:	DCEP (+)

DIAMETER	AMPS	VOLTS	SHIELDING GAS	FLOW RATE
0.045" (1.2mm)	190-320	22-35	CO ₂ or Ar + CO ₂	14-20 l/min
1/16" (1.6mm)	210-380	23-37		30-42 scfh

Specifications: AWS/ASME A5.36:
E81T1-M21A8-Ni1-H4

Certified by the CWB to CSA W48-14:
E551T1-C1A4-Ni1-H4 (CO₂)
E551T1-M21A6-Ni1-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
- Earth Moving Equipment
- Mining Equipment
- Steels to API Standards
- Boiler Steel
- Unalloyed Structural Steels
- Fine Grained Steels
- Pressure Vessels
- Pipe Work
- Off Shore Structures
- High Strength Steel Structures

