



High Performance Seamless Cored Wire  
for Joining Applications

# **EnD0tec®**

## **DO\*275**



- Enhanced arc stability and less spatter
- Low heat input and fume emissions
- High yield Ni-Cr-Mo alloy
- Especially suitable for automated applications

# EnDotec® DO\*275

High Performance Ni-Cr-Mo alloyed seamless metal cored wire for single or multipass welding of high strength steels with Ar-CO<sub>2</sub> shielding gas.

## 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:	161,000 psi (1110 MPa)
Yield Strength:	136,300 psi (940 MPa)
Elongation:	15%
Charpy V-Notch KV -40°F (-40°C)	> 47J
Charpy V-Notch KV -60°F (-51°C)	> 27J
Current Polarity:	DCEP (+)

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

Specifications: AWS/ASME A5.28 E120CG

## 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

- High Load and High Stress Bearing Steel Structures
- Bridge Abutments
- Gantry Frameworks
- Highly Stressed Earthmoving Equipment



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