



Elgacore 110B

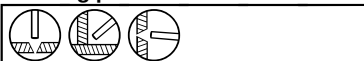
FCAW - Flux cored arc welding
Low-alloyed

Date: 2007-06-13
Revision: 6

Description:

Elgacore 110B is a basic flux cored wire suitable for welding high-strength low-alloy steels such as Weldox 700, T1 and HY 80. It can be used with either Ar/CO₂ or straight CO₂ shielding gas. The wire operates with a stable arc to produce good weld bead appearance, easy slag removal and excellent fracture toughness at temperatures down to -50°C. The wire is supplied as standard on a K-300 wire basket spools.

Welding positions:



Welding current:

DC +

Deposition efficiency:

85%

Shielding gas:

100% CO₂, 12-16 l/min.

80% Ar/20% CO₂, 12-16 l/min.

Stick-out:

15-25 mm

Hydrogen content / 100 g weld metal

≤5 ml

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min	0.03		1.4			0.3	1.8
Typical	0.05	0.4	1.7	0.01	0.01	0.4	2.2
Max	0.10	0.80	2.0	0.02	0.02	0.6	2.6

	Mo	Cu	V	Nb
Min	0.3			
Typical	0.4		<0.02	
Max	0.6	0.3	0.03	0.05

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Re:	>690 N/mm ²	800 N/mm ²
Tensile Strength, Rm:	770-900 N/mm ²	860 N/mm ²
Elongation, A5	>17%	18%
Impact energy, CV:	-50°C • >47 J	-51°C • 80 J

Classification:

EN 12535

T Mn2NiCrMo B C/M 4 H5

AWS A5.29

E 110 T5 K4

Approvals:

TÜV

09032.01

Product data:

Diam.mm	Product code	Spool weight
1,2	95901012	16 kg WBS