



Elgacore MXA 100

FCAW - Flux cored arc welding
Un-alloyed

Date: 2013-05-27
Revision: 21

Description:

Elgacore MXA 100 is a metal cored wire for use with an Ar/CO₂ gas shield, designed for high productivity welding in the horizontal and horizontal-vertical positions. The wire runs with a stable, low spatter and deep penetrating arc. The slag produced is of a very low level, similar to that from a solid wire and inter-run deslagging is not necessary. Combined with a highly reliable arc-start, these characteristics make Elgacore MXA 100 an ideal choice for robotic or mechanised welding. Elgacore MXA 100 produces a very low hydrogen weld metal and good mechanical properties. Suitable for general fabrication and structural steels.

Welding positions:



Welding current:

DC+

Deposition efficiency:

96%

Shielding gas:

M21, 80% Ar + 20% CO₂, 22-25 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							
Typical	0.05	0.75	1.55	0.011	0.009		
Max	0.12	0.90	1.75	0.03	0.03	0.20	0.50

	Mo	Cu	V	Nb
Min				
Typical				
Max	0.20	0.30	0.08	0.05

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Re:	≥ 420 MPa	460 MPa
Tensile Strength, Rm:	500-640 MPa	555 MPa
Elongation, A5	≥ 22%	30%
Impact energy, CV:	-40°C • 47 J	-40°C • 80 J

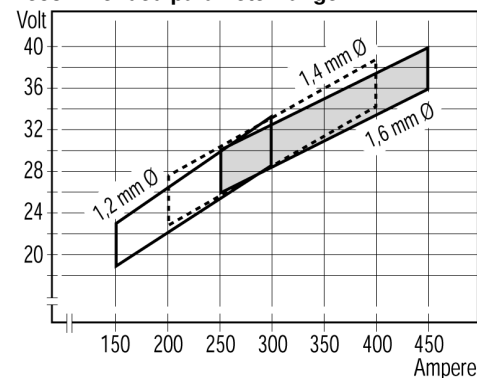
Classification:

EN 758	T 42 4 M M 3 H5
AWS A5.18	E 70C-6M
ISO 17632-A	T 42 4 M M 3 H5

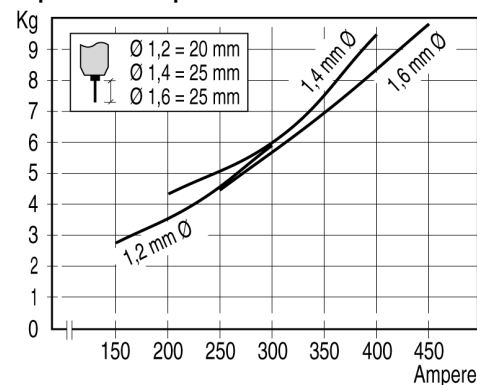
Approvals:

TÜV	07657.01
GL	4YH5S
ABS	3YSA
DB	42.042.10
LR	3S, 4YS H5
MRS	4Y42MSH5
CE	

Recommended parameter range:



Deposition rate per hour:



Product data:

Diam.mm	Product code	Spool weight
1,2	95621012	15 kg BS300
1,2	95622112	5 kg D200
1,2	95622212	250 kg ProPac
1,4	95621014	15 kg BS300
1,4	95622214	250 kg ProPac

Note

Strip:
S ≤ 0.015%
P ≤ 0.025%
N ≤ 0.004%

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