



Elgacore MX 100T

FCAW - Flux cored arc welding
Un-alloyed

Date: 2013-05-27
Revision: 20

Description:

Elgacore MX 100T is a metal cored wire for use with a CO₂ or Ar/CO₂ gas shield, specially designed for single-sided welding of thinner section material. The wire is all-positional and runs with a very stable, spatter-free arc even under dip transfer conditions at welding currents as low as 50 A. Root passes normally made with the TIG or MMA process can be carried out with Elgacore MX 100T to give significantly increased productivity, making the wire particularly suitable for pipe welding. Elgacore MX 100T has good notch toughness properties down to -30°C and is recommended for general fabrication and structural steel work.

Welding positions:



Welding current:

DC+

Deposition efficiency:

96%

Shielding gas:

M21, 80% Ar + 20% CO₂, 22-25 l/min
C1, 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	0.07	0.5	1.5	0.015	0.014		
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	450 MPa
Tensile Strength, Rm:	500-640 MPa	570 MPa
Elongation, A5	≥ 22%	29%
Impact energy, CV:	-20°C • 47 J	-20°C • 100 J -30°C • 75 J

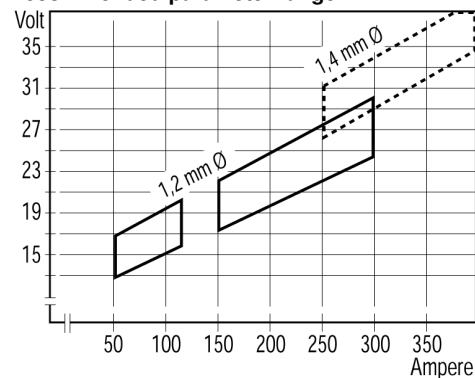
Classification:

EN 758	T 42 2 M C/M 1 H5
AWS A5.18	E 70C-6M/-6C
ISO 17632-A	T 42 2 M C/M 1 H5

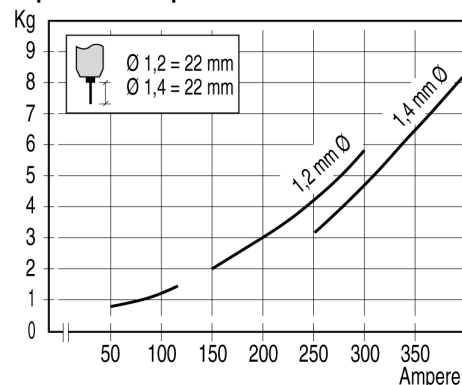
Approvals:

GL	3YH5S
LR	3S, 3YS H5
MRS	3Y40MS HHH
DNV	III YMS H5
DB	042.42.11
TÜV	07701.00
CE	

Recommended parameter range:



Deposition rate per hour:



Product data:

Diam.mm	Product code	Spool weight
1,2	95651012	15 kg BS300
1,2	95651112	5 kg BS200

Note

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

