

❖ Product Description

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| I. Gas shielded, rutile type FCW wire | IV. Low fumes, very less spatter |
| II. Designed for high strength, fine grained and quenched steels like N-A-XTRA70, USS T1, T1B | V. Excellent mechanical properties |
| III. Contains typical 2%Ni | VI. Stable arc and easy slag removal |
| | VII. Radiographic weld quality |

❖ Range of Application

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| I. Extremely good for welding of fine grained and quenched steels | III. For joining ASTM grades C, D of SA-225/225M |
| II. Also suitable for fabrication of earth moving equipment, steel constructions, crane plates etc | IV. Finds usage in refineries, power plant, pressure vessels, boilers |

❖ Classification

- AWS/SFA 5.29 E110T5-K4C

❖ % Chemical Composition

Type of Wire		C	Mn	Si	S	Mo	Ni	Cr	P	V
E110T5-K4C	Min	-	1.20	-	-	0.20	1.75	0.20	-	-
	Max	0.15	2.25	0.80	0.030	0.65	2.60	0.60	0.030	0.03

❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charphy "v" Notch Impact @ -50°C
PWHT	760	680	15	27min

❖ Wire Size & Welding Position

- Diameter in mm- 1.2, 1.6
- Weld Position- All position

❖ Current & Gas Flow

- DCEP; 18-25lit/min

❖ Packaging

- Standard packaging in 15kg Spool form

Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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