

# Supercored 110

Type : Rutile

## Conformances

AWS A5.36/ ASME SFA5.36 E111T1-C1A4-G H4

(AWS A5.29/ ASME SFA5.29 E111T1-GC H4)

EN ISO 18276-A-T 69 4 ZMn2.5NiMo P C1 1

ABS AWS A5.29 E111T1-GC-H4 (IV-40°C ≥41J)

KR 3Y69S(C) H5

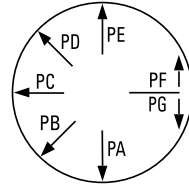
## Applications

- Offshore structure
- High tensile welded structure

## Features

- Good impact value at low temperature
- Pre-heat recommended

## Welding Position



## Current

DC +

## Shielding Gas

100% CO<sub>2</sub>

## Diameter / Packaging

Diameter	Spool			Pac		
	12.5kg (28lbs)	15kg (33lbs)	20kg (44lbs)	100kg (221lbs)	200kg (441lbs)	250kg (551lbs)
mm (in)						
1.2 (0.045)	√	√	√			

**Typical Chemical Composition of All-Weld Metal (%)**

C	Si	Mn	P	S	Ni	Mo
0.06	0.35	1.55	0.016	0.007	2.20	0.50

**Typical Mechanical Properties of All-Weld Metal**

YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.-lbs)
780 (113,000)	830 (121,000)	19.9	-40 (-40)	60 (44)

**Typical Welding Parameters**

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)	Efficiency (%)
<b>1.2mm (0.045 in) DC+</b>						
100% CO <sub>2</sub>	25 (1)	<b>All Position</b>				86-88
		4.4 (175)	140	23-28	1.6 (3.5)	
		5.1 (200)	150	24-29	1.8 (4.0)	
		6.4 (250)	165	25-30	2.3 (5.0)	
		7.6 (300)	190	25-30	2.7 (6.0)	
		8.9 (350)	205	26-31	3.2 (7.0)	
		9.5 (375)	225	26-31	3.4 (7.5)	
		10.8 (425)	245	27-32	3.8 (8.5)	
		<b>Flat &amp; Horizontal</b>				
		12.1 (475)	265	28-33	4.9 (10.8)	
12.7 (500)	275	29-34	5.2 (11.4)			

SMW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX