

Coreweld 111 Ultra

Semi-metal type FCAW wire for mild steel and 490N/mm² class high tensile strength steel. Coreweld 111Ultra is a low slag type cored wire with a bright surface finish that is specially designed to provide very high deposition rates, high deposition efficiency, and low fume emission rates. This wire is most suitable for fillet welding of inorganic zinc primer coated steels in the shipbuilding.

Specifications

Classifications

SFA/AWS A5.20 : E70T-1C/9C
SFA/AWS A5.20 : E70T-9
JIS Z 3313 : T492T1-0CA-U
JIS Z 3313 : YFW-C502M
KS D 7104 : YFW-C502M

Approvals

ABS : 3YA H10
ABS : 3YSA H10
BV : A3YM
CCS : 3YSH10
CCS : 3M, 3YM
CE : EN 13479
ClassNK : KAW53MG(C) - Tandem
DNV : III YMS(H10)
KR : 3YMG (C)
RS : 3YSH5 & 3YMH5
UKCA : EN 13479
BV : SA3YM
CCS : 3SH10, 3YSH10
KR : 3YSG
LR : 3YM
LR : 3YS H10
RINA : 3Y S H10

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current

DC+

Alloy Type

C Mn Ni

Shielding Gas

C1 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
C1 Shielding gas			
As Welded	500 MPa	580 MPa	30 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
C1 Shielding gas		
As Welded	-20 °C	67 J
As Welded	-30 °C	43 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni
0.057	1.375	0.652	0.348

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	150-330 A	28-34 V	5.1-15.2 m/min	1.9-5.9 kg/h
1.6 mm	190-500 A	27-39 V	3.8-12.7 m/min	2.8-9.1 kg/h
2.0 mm	250-450 A	26-31 V	2.8-6.6 m/min	2.9-6.7 kg/h