

Dual Shield 110C

An all-positional rutile cored wire for welding high strength steel with a minimum yield strength of 690 MPa and toughness down to -60 degrees C for use with carbon dioxide shielding gas.

Specifications

Classifications	SFA/AWS A5.29 : E111T1 GC H4 EN ISO 18276-A : T 69 6 Z P C1 2 H5
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Welding Current	DC+
Alloy Type	Low Alloy (Ni Mo)
Shielding Gas	C1 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
C1 AWS			
As Welded	761 MPa	840 MPa	18 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
C1 AWS		
As Welded	-60 °C	60 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Mo
C1 Shielding gas				
0.055	1.21	0.39	2.3	0.4

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	100-300 A	21-32 V	3.2-14.5 m/min	1.3-5.8 kg/h