



110T5-K4 FLUX CORED Welding Wire

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com

WASHINGTON ALLOY'S Quality
Management System is
Certified to **ISO 9001:2008**
Cert # 05-R0925



ALLOY DESCRIPTION AND APPLICATION:

110T5-K4 is a flux cored wire designed for single or multi pass using CO₂ or Argon /CO₂ shielding gas welding having a smooth spray-type transfer commonly used on low alloy steels. This all position wire normally used in high strength applications which will produce a chemical composition of 2 % nickel , 0.5 % molybdenum and 0.20-0.70 % chromium yielding strengths ranging from 110-130 ksi. Steels commonly welded with this grade would include T-1, HY-80, HY-100, ASTM A710, ASTM A514 and similar grades .

TYPICAL FCAW WELDING PROCEDURES; DCEP with 100% CO₂ (35-45cfh)

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stickout
0.045"	385	260	28	1/2-1"
1/16"	340	315	30	1/2-1"

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.(**Based on FLAT**) for mixed gas lower the voltage by 2-5 %

UNDILUTED WELD METAL (%) AND WELD METAL PROPERTIES;

	AWS Spec.		AWS Spec
Carbon	0.15 max.	Tensile Strength (psi)	110-130,000
Manganese	1.20-2.25	Yield Strength (psi)	98,000 min.
Nickel	1.75-2.60	Elongation in 2"	15% min.
Chromium	0.20-0.60	Charpy V-notch (-60°F)	20 ft-lbs min
Silicon	0.80 max.		
Molybdenum	0.20-0.65		
Phosphorus	0.03 max.		
Sulfur	0.03 max.		
Vanadium	0.03 max.		

AVAILABLE SIZES: TCF 110T5-K4= Spools of .045,
Other sizes may be available – please inquire

SPECIFICATIONS; ANSI/AWS A5.29 E110T5-K4C , E110T5-K4M
ASME SFA A5.29 E110T5-K4C , E110T5-K4M

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