Pipeweld 111T-1

An all positionable rutile flux cored wire that is used with Ar-CO2 shielding gas.This wire offers excellent weldability. Suitable for up to X100 strength pipe.

Classifications Weld Metal	SFA/AWS A5.36 : E111T1-M21A4-K3-H4 SFA/AWS A5.29 : E111T1-K3MJ-H4 EN ISO 18276-A : T 69 4 2NiMo P M21 2 H5

Welding Current	DC+
Alloy Type	Low Alloy (Ni Mo)
Shielding Gas	M21 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
M21 shielding gas			
As Welded	761 MPa (110 ksi)	840 MPa (122 ksi)	19 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
M21 shielding gas		
As Welded	-40 °C (-40 °F)	60 J (44 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Mo
0.055	1.21	0.39	2.3	0.4

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate	TTW Dist.
1.2 mm (0.045 in.)	150-350 A	21-32 V	5.6-19.8 m/min (220-780 in./min)	2.1-7.5 kg/h (4.6-16. lb/h)	-

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