MAXFIL-1101G5

Basic Type Flux Cored Wire

CODIFICATION: AWS/SFA 5.29
E110T5-GC

CHARACTERISTICS AND APPLICATIONS:

Maxfil-1101G5 is a low alloy steel flux cored wire designed for welding of high tensile strength steel, quenched & tempered steels, etc. The weld metal also results good impact resistance property at sub-zero temperatures. The wire gives optimum performance under CO2 shielding with radiographic quality weld deposits. The weld has excellent bead appearance and easy slag removal.

Maxfil-1101G5 is designed for single and multi-pass welding of similar composition steels and equivalent grade steels like; HY-80, Sumiten-610, C/D grades of SA-225, B/C grades of SA-543, steels conforming to SA-612 grade, A/B/C grades of SA-738, etc.

CHEMICAL COMPOSITION OF ALL WELD METAL (%):

Element	C	Mn	Si	S	P	Ni	Mo
Typical	0.080	1.42	0.46	0.012	0.018	2.20	0.36

MECHANICAL PROPERTIES OF ALL WELD METAL:

Property	UTS (Mpa)	YS (Mpa)	%El (L=4d)	CVN Impact (Joules) at -40°C	-51°C
As Weld	815	710	20.0	67	45

WELDING POSITIONS: H, F, VU

WELDING PARAMETER: DC (+)

Diameter	HORIZONTAL		FLAT		VERTICAL UP	
(mm)	Volt, V	Current, A	Volt, V	Current, A	Volt, V	Current, A
1.20	24-28	160-260	24-28	160-260	18-22	100-160
1.60	24-28	180-300	24-28	180-300	18-22	110-200

SHIELDING GAS : Carbon Dioxide CO_2 (100%) at flow rate 12-15 litres per minute.

PACKING :

Standard size : 1.20 & 1.60mm. Other diameters may be available on request.

Quantity : Supplied approximately 15Kgs in a plastic spool. Each spool is sealed in an air tight polythene bag and then packed in a corrugated box.