



# Smoothcor 100T5-D2C/100T5-D2M

**Classification:** AWS A5.29/ASME SFA 5.29 E100T5-D2C/E100T5-D2M

**Description:** Smoothcor 100T5-D2C/100T5-D2M is a low alloy steel electrode with a basic slag system used to weld certain manganese-molybdenum steels and castings. This electrode is intended for single and multiple pass welding in horizontal fillets and the flat position.

Smoothcor 100T5-D2C/100T5-D2M produces deposited weld metal of approximately 2% manganese and .5% molybdenum, used primarily to weld steels such as ASTM A302 GrB and castings such as ASTM A49, A291 and A735. It has excellent low temperature CVN toughness. Basic slag that provides weld metal with low levels of diffusible hydrogen. The weld deposit is suitable to match composition of Mn-Mo castings. It is a direct replacement for E10018-D2.

Shielding gas: E100T5-D2C: 100% CO<sub>2</sub> / E100T5-D2M: 75%Ar/25%CO<sub>2</sub>

## Typical Weld Deposit Chemistry

C	Mn	P	S	Si	Mo
.05	2.06	.01	.01	.45	.48

## Typical Mechanical Properties (CO<sub>2</sub>)

	SR 1hr. @1150°F
Tensile Strength	110,000 psi
Yield Strength	95,000 psi
Elongation	24%
CVN (ft•lb f) @ -40°F	30

## Suggested Welding Parameters

Dia.	Operating Range		Optimum		
	Amps	Volts	Amps	WFS (ipm)	Volts
.045"	120-320	22-31	250	380	28
1/16"	250-450	26-34	300	320	29

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus, the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.