E110T5-K3

Classification AWS A5.29/ASME SFA 5.29 E110T5-K3C

E110T5-K3 is a basic low alloy steel, gas shield, flux cored electrode designed for horizontal fillet and flat position welding of HSLA steels. It is intended for single and multiple pass welding. The arc transfer is globular with a convex bead profile. E110T5-K3 produces weld metal tensile strength of 110,000 psi minimum. It has excellent low temperature CVN toughness and low diffusible hydrogen levels, this makes **E110T5-K3** an excellent choice for welding high strength, low alloy steels such as T-1, ASTM A514 and HY-100. **E110T5-K3** meets the same requirements as E11018-M electrodes. Shielding Gas: 100% CO_2, 40-55 cfh.

Typical Weld Deposit Chemistry (CO_2)

	C	Mn	P	S	Si	Ni	Mo
CO_2	.04	1.64	.01	.01	.46	2.01	.46

Typical Mechanical Properties (CO_2)

Tensile Strength	116,000 psi
Yield Strength	104,000 psi
Elongation	20%
CVN (ft●lb *f*) @ -60°F	39

Typical Welding Parameters – Carbon & Low Alloy – Flat & Horizontal - CO_2 – DCEP

Dia.	Operating Range			Optimum			
	Amps	WFS (ipm)	Volts	Amps	WFS (ipm)	Volts	ESO
.045”	130-300	160-670	21-32	250	450	28	½ - 1”
1/16”	150-400	130-500	22-34	330	330	29	½”-1”

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. Unibraze disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.