Coreweld 111 Ultra

AWS A5.20 E70T-9C / JIS Z3313 T492T1-0CA-U

Description

- ESAB SeAH Coreweld 111 Ultra is a high efficiency, low slag type cored wire with a bright surface finish that is specially designed to provide very high deposition rates, high deposition efficiency approaching that of solid wires, and low fume emission rates. It is optimized for use with 100% CO_2 shielding. Coreweld 111 Ultra is capable of operating with a very wide current range and has the ability to sustain good arc stability at higher current levels than are typically associated with small diameter cored wires. The bright surface finish provides excellent feedability and arc starting characteristics.
- The weld surface is smooth with virtually no spatter and a very thin easily removed slag. Fillet welds are flat to slightly convex. A unique advantage of this product is its ability to produce clean porosity free welds over primer painted surfaces. Coreweld 111 Ultra has been designed for general purpose use in the flat and horizontal welding positions. However in diameters of 1.4mm and less it is capable of producing good welding characteristics in the vertical up and down positions also. It has particular applications in shipyard welding where high efficiency and versatile operation are most important and is widely used on panel line applications. It may be used in a variety of other applications including railcar, automotive, heavy equipment, and general structural steel fabrication. It is especially recommended in applications where reduction of welding fume and high welding speed is important.

Shielding Gas : 100%CO_2

Typical Mechanical Properties of All Weld Metal

Yield Point N/mm²{kgf/mm²}	Tensile Strength N/mm²{kgf/mm²}	Elongation (%)	Impact Value J(kgf · m)	
			0℃	-20℃
510 {52}	570 {58}	27	67 {6.8}	43 {4.4}

Typical Undiluted Weld Metal Analysis %

C	Mn	Si	S	P	Ni
0.06	1.61	0.64	0.011	0.011	0.35

Approvals

ABS, LR, DNV, BV, GL, CCS, RINA, KR, JIS