

# Dual Shield II 101-TC

AWS A5.29 E91T1-K2C / JIS Z3313 T622T1-1CA-N3M1

## Description

- Dual Shield II 101TC is a second generation series high strength flux cored electrode that produces low hydrogen deposits in all positions. The low fume, reduced spatter and flat weld bead produces enhanced welder appeal. Mechanical properties include improved low temperature notch toughness.

Flux  
CORED  
WIRES

## Shielding Gas : 100%CO<sub>2</sub>

## Application

- Dual Shield II 101TC, like its companion Dual Shield II 101TM(for 75% Ar/25% CO<sub>2</sub>), was developed to meet the stringent Military Specification MIL-E-24403/2. It is intended for use on HY-80, ASTM A710, A514, and A517 or other similar high strength low alloy steels.

## Typical Mechanical Properties of All Weld Metal

Yield Point N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	Tensile Strength N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	Elongation (%)	Impact Value J(kgf · m)		
			-20 °C	-30 °C	-40 °C
604 {62}	649 {74}	23	128 {13.0}	112 {11.4}	80 {8.2}

## Typical Undiluted Weld Metal Analysis %

C	Mn	Si	P	S	Ni
0.04	1.42	0.43	0.011	0.006	1.67

## Approvals

ABS, DNV, KS, JIS