

Dual Shield II 110

AWS A5.29 E111T1-K3C/M

Flux
CORED
WIRES

Description

- Dual Shield II 110 electrodes are a breakthrough in all position flux-cored technology. Prior to the development of the patented Dual Shield II series, no all-position flux-cored electrode combined tensile strengths in excess of 100,000 psi with good low temperature impact properties. Dual Shield II 110 combines both strength and toughness with all position versatility. This balance of physical properties is coupled with operator appeal. Smooth spray type transfer, low spatter levels, easy slag removal and good arc drive are all incorporated into Dual shield II 110 electrodes, a constant potential power source operating on DC reverse polarity is needed for proper operation. To retain the excellent arc characteristics and physical properties of the weld metal, a 75%Argon/25% CO₂ shielding mixture must be used. The standard preheat, interpass, and postheat procedures that are used in welding high strength steel with low hydrogen coated electrodes also apply to Dual Shield II 110 electrodes.

Shielding Gas : 100%CO₂ or 75%Argon/25%CO₂

Application

- Dual Shield II 110 is designed to join high strength steel such as HY-100 and T-1 in the "as welded" or "stress relieved" condition. It is well suited for joining high tensile steels that will be used in a low temperature environment.

Typical Mechanical Properties of All Weld Metal (All Weld Metal Using 100% CO₂)

Yield Point N/mm ² {kgf/mm ² }	Tensile Strength N/mm ² {kgf/mm ² }	Elongation (%)	Impact Value J(kgf · m)	
			-20 °C	-30 °C
735 {75}	830 {85}	21	54 {5.5}	49 {5.0}

Typical Undiluted Weld Metal Analysis %

C	Mn	Si	P	S	Cr	Ni	Mo
0.05	1.63	0.30	0.014	0.006	0.02	1.66	0.35

Approvals ABS