

Dual Shield T-115

AWS A5.29 E110T5-K4M

Description

- Dual Shield T-115 is a flux cored multipass electrode with a basic type slag designed for applications requiring a high strength weld deposit of excellent quality. The weld metal chemistry and mechanical properties are similar to the E11018-M covered electrodes.

Flux
CORED
WIRES

Shielding Gas : 75%Ar/25%CO₂

Application

- Dual Shield T-115 deposits weld metal which has a high resistance to cracking in heavy sections and in weldments under high restraint. It has good usability with a minimum amount of spatter and easy slag removal. It can be used for welding steels such as: T-1, HY-80, HY-90, N-A-XTRA 90, 100 and 110, and the SSS 100 series.

Typical Mechanical Properties of All Weld Metal

Yield Point N/mm ² {kgf/mm ² }	Tensile Strength N/mm ² {kgf/mm ² }	Elongation (%)	Impact Value J(kgf · m)		PWHT
			-30 °C	-50 °C	
755 {75}	813 {87}	20	68 {6.9}	66 {6.7}	As-Welded
686 {70}	774 {79}	23	49 {5.0}	43 {4.4}	565°C x1hr

Typical Undiluted Weld Metal Analysis %

C	Mn	Si	Ni	Mo	P	S	Cr
0.07	1.72	0.45	2.16	0.47	0.018	0.006	0.22

Approvals

ABS