



Product Data Sheet

Prepared by	Approved by	PDS No & Rev.	Issue Data.	Page
W.Kil	MC Kim	PDS-01-44 / Rev.0	2005. 11. 17.	1/2

Coreweld 111RB

Semi-metal type FCAW wire for mild steel and 490N/mm² class high tensile strength steel

General

Coreweld 111RB is a low slag type cored wire with superior pit resistance in welding of primer coated steels. This wire shows good usability similar to conventional flux cored wires but provides high deposition rate and high deposition efficiency.

Shielding Gas: C1

Alloy Type: C Mn Ni

Fill Type: Metal

Classifications Weld Metal

ASME SFA/AWS A5.20 E70T-1
KS D 7104 / JIS Z 3313 YFW-C50DM

Approvals

ABS 2SA 2YSA H10 (C1)
3A 3YA H10 (C1) - Tandem
BV SA2YM HH(C1)
A3M,A3YM (C1) - Tandem
DNV IIYMS H10 (C1)
IIIYM (C1) - Tandem
GL 2YH10S (C1)
KR RSW 52G HH(C1)
RAW53MG (C1) - Tandem
LR 2YS H15(C1)
3YM H15(C1) - Tandem
NK KSW52G H10(C1)
RINA 2YS H10 (C1)

Welding Parameters

Diameter	Position	Current (A) Range	Voltage (V) Range
1.2mm	Flat	140 ~ 330	22 ~ 34
	Vertical - up	-	-
1.4mm	Flat	160 ~ 390	23 ~ 38
	Vertical - up	-	-
1.6mm	Flat	170 ~ 460	24 ~ 42
	Vertical - up	-	-

*DC Electrode Positive (Reverse) Polarity, Electrical Stick out: 13 ~ 25mm



Product Data Sheet

Prepared by	Approved by	PDS No & Rev.	Issue Date.	Page
W.Kil	MC Kim	PDS-01-44 / Rev.0	2005. 11. 17.	2/2

Chemical Composition of Weld Metal				Diffusible Hydrogen of Weld Metal		
	All Weld Metal (%)					
	Min	Max	Typical			
C	0.03	0.08	0.053			
Si	0.30	0.80	0.580			
Mn	0.90	1.70	1.548			
P		0.025	0.013			
S		0.025	0.009			
Cr		0.2	0.023			
Ni		0.1	0.016			
Mo		0.2	0.002			
V		0.08	0.012			
Nb		0.05	0.008			
Cu		0.3	0.019			

Mechanical Properties of Weld Metal

Properties	All Weld Metal CO ₂ Shielding Gas (C1)			80%Ar/20%CO ₂ Shielding Gas (M21)		
	As welded			As welded		
	Min	Max	Typical	Min	Max	Typical
Yield Strength (MPa)	400		464			
Tensile Strength (MPa)	490	660	548			
Elongation (%)	22		32			
CVN Impact Value (J)						
-0°C			89			
-18°C			50			

Standard Packaging

Diameter	Spool	Pail
1.2mm	12.5, 15kg	100, 200kg
1.4mm	12.5, 15kg	100, 200kg
1.6mm	12.5, 15kg	300kg