ELCOR M 110

Standards

EN ISO 18276-A	: T 69 4 Mn2NiCrMo M M21 1 H5
EN ISO 18276-B	: T 76 5 T15 1 M21 A N4C1M2 H5
AWS A5.36	: E111T15 M21 A8 K4 H4

Chemical Composition of Weld Metal % (Typical)

C	Si	Mn	Cr	Ni	Mo
0.08	0.4	1.6	0.5	2.3	0.4

Mechanical Properties

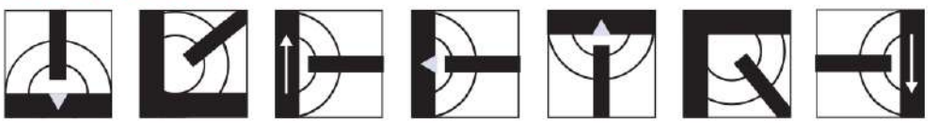
Heat Treatment	Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/-60°C)	(ISO-V/-50°C)	(ISO-V/-40°C)	Elongation ($(L_o=5d_o)$ (%)
AW	min.690	775-795	30	45	50	min.15

AW: as welded

Features and Applications

- Tubular cored wires of the M type are characterized by a very fine droplet spray metal transfer and minimal slag cover.
- This type of electrode is commonly used in the fabrication of high strength steels and vessel steel construction, mechanical engineering and pipe work.
- Excellent gap bridging for root welding.
- Fast freezing characteristics facilitate butt and fillet welding. Smooth arc, low spatter arc and good weldability.

Welding Positions



Current Type

D.C (+), D.C (-)