ALLOY 11100-74

Description:

ALLOY 11100-74 is a carbon steel with low Niquel, flux cored electrode for use without external gas-shielding in multiple pass welding of carbon steels and cast iron . This electrode is intended for flat position welding of grooves and fillets and horizontal fillet welding with extremely high deposition rates.

Classification:

- E70T-4 per AWS A5.20, SFA 5.20.

Characteristics:

ALLOY 11100-74 is a self-shielded, flux cored electrode intended to weld with a globular transfer, moderate splatter, and high deposition rates. The highly basic slag minimizes hot cracking on steels high in sulfur. Joint penetration is good penetration, which facilitates welding fillets with gaps or poor fit up. Slag detachment is quite good, and the bead profile is slightly convex.

Applications:

ALLOY 11100-74 is ideal for those welding applications where gas- shielded electrodes may have problems, such as outdoors or in windy conditions. These would typically be light gauge steel plate fabrication or general purpose fabrication of carbon steels. **ALLOY 11100-74** is also a good choice in poor fit up situations or when extended stickouts must be used in hard-to-reach areas.

Typical Mechanical Properties:

Ultimate Tensile Strength (psi):	87,800
Yield Strength (psi):	65,000
Percent Elongation:	26.5

Typical Deposit Composition:

Wt%	Ni	C	Mn	Si	P	S	Al
	4.	.20	.50	.17	.008	.003	1.59

Recommended Welding Parameters (DCEP):

	Optimum			
Diam.	Amps	Volts	WFS(ipm)	CTWD
1/16”	200	30	205	1¾"
5/64"	250	30	185	2¾"
3/32"	350	30	190	2¾"
.120"	450	31	135	2¾"

Rev 0 (03/05/2014)