

MIDALLOY MASTERCOR E101T1-G FLUX-CORED WIRE

CLASSIFICATION

- AWS 5.29 Class E101T1-G / AWS/ANSI A5.29 Class E101T1-G

DESCRIPTION

- MIDALLOY MASTERCOR E101T1-G flux-cored wire is an all position, gas shielded flux-cored wire with high strength properties in the as-welded condition. This wire is intended for single and multiple pass welding of quenched and tempered steels that require post-weld heat treatment.

APPLICATIONS

- MIDALLOY MASTERCOR E101T1-G flux-cored is designed to weld oil field components that require post-weld stress relief.
- This wire can be used for welding quenched and tempered steels such as 4130, 8630, and similar types. Weld metal nickel contents of less than 1.0% meet NACE requirements.
- This wire may also be used for welding high strength, low alloy steels, where 100,000 PSI minimum tensile strength, as well as excellent toughness are required in the as welded condition.

TYPICAL DEPOSIT CHEMISTRY

C	Mn	Si	P	S	Ni	Mo
0.06	1.40	0.30	0.011	0.007	0.85	0.35

TYPICAL MECHANICAL PROPERTIES

	AS WELDED	SR- 1150°F/1 HOUR	SR- 1175°F/8 HOURS
Tensile Strength	111,100 PSI	103,000 PSI	106,400 PSI
Yield Strength	98,700 PSI	94,000 PSI	99,100 PSI
% Elongation	19	22	22
CVN (ft-lb)	65 @ -20°F	36 @ -20°F	22 @ -25°F
	47 @ -50°F		

TYPICAL WELDING PARAMETERS

DIAMETER	POSITION	OPTIMUM			RANGE	
		Amps	WFS	Volts	Amps	Volts
.045"	Flat	250	282	27	100-300	20-31
	Overhead	200	265	25	150-280	21-28
	Vertical Up	200	265	24	100-230	21-27
1/16"	Flat	350	300	28	150-400	21-33
	Overhead	225	160	25	150-310	22-27
	Vertical Up	225	160	24	150-280	22-26

Shielding Gas – Use 75%Ar/25%CO₂ Only
Flow Rates 35-50 cfh

STANDARD PACKAGING

- 33 lb. spool

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