

## MIDALLOY MASTERCOR E101T1-K3C FLUX-CORED WIRE

### CLASSIFICATION

- AWS 5.29 Class E101T1-K3C / AWS/ANSI A5.29 Class E101T1-K3C

### DESCRIPTION

- MIDALLOY MASTERCOR E101T1-K3C flux-cored wire is an all position, CO<sub>2</sub> 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 may or may not require post-weld heat treatment.

### APPLICATIONS

- MIDALLOY MASTERCOR E101T1-K3C flux-cored is designed to weld oil field components that may or may not require post-weld stress relief.
- This wire can be used for welding quenched and tempered steels such as 4130, 8620,T1 and similar types.
- Outstanding low temperature impact toughness.
- 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 is required in the as-welded condition.
- This wire is used in the shipbuilding (HY80, HY100) and high strength lifting equipment (ASTM 514 T1).

### TYPICAL DEPOSIT CHEMISTRY

C	Mn	Si	P	S	Ni	Mo
0.06	1.40	0.30	0.011	0.007	1.92	0.41

### TYPICAL MECHANICAL PROPERTIES

	AS-WELDED
Tensile Strength	106,100 PSI
Yield Strength	92,300 PSI
% Elongation	22
CVN (ft.-lbs.)	56 @ 0°F
	45 @ -20°F

### TYPICAL WELDING PARAMETERS

DIAMETER	POSITION	OPTIMUM			RANGE	
		Amps	Wire Feed (ipm)	Volts	Amps	Volts
.045"	Flat	250	450	28	130-300	20-31
	Overhead	200	315	26	150-280	21-30
	Vertical Up	200	315	25	130-260	21-29
1/16"	Flat	330	330	29	150-400	22-34
	Overhead	225	180	26	150-310	22-28
	Vertical Up	225	180	25	150-280	22-27

Shielding Gas – Use CO<sub>2</sub> Only  
Flow Rates 35-50 cfh

### STANDARD PACKAGING

- 33 lb. spool

1/4/12

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