



Select 111-K3M

Description:

- A low alloy steel, flux cored, gas shielded electrode
- Intended for single and multiple pass welding of various high strength, low alloy steels in all positions
- For use with blends of 75-80% Ar/balance CO₂
- Well suited for structural and fabrication welding of steels such as ASTM A514, A710, and HY-80 material
- Typical applications would be cranes, trailers, and mining truck frames

Classifications & Approvals:

- E111T1-K3M per AWS A5.29, SFA 5.29
- E111T1-C1A2-K3 per AWS A5.36, ASME SFA 5.36
- ABS as E111T1-K3MJ

Typical Mechanical Properties:

Ultimate Tensile Strength (psi)	117,400
Yield Strength (psi)	111,600
Percent Elongation	22
CVN (ft-lbf) @ -20° F	42

Typical Weld Deposit Chemistry:

Wt. %	C	Mn	P	S	Si	Ni	Mo	Cr	V
	.07	2.03	.007	.003	.38	1.99	.38	.06	.014

Typical Welding Parameters:

Diameter	Position	Amperage	Optimum			Range	
			WFS	Voltage	Amperage	Voltage	
1/16"	Flat	350	300	29	150-400	22-34	
	Overhead	225	160	26	150-310	22-28	
	Vertical up	225	160	25	150-280	22-27	
.052"	Flat	300	360	28	100-330	19-32	
	Overhead	225	245	26	150-310	21-28	
	Vertical up	225	245	25	150-280	21-27	
.045"	Flat	250	282	28	100-300	21-32	
	Overhead	200	265	26	150-280	21-29	
	Vertical up	200	265	25	100-230	21-28	

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. Select-Arc disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.

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