



## Select 115-K3

### Description:

Select 115-K3 is a low alloy steel, gas-shielded, flux cored electrode for horizontal fillet and flat position welding of certain HSLA steels. This electrode is capable of single and multiple pass welding. The arc transfer is globular with a convex bead profile due to the nature of a basic slag system.

### Classification:

- E110T5-K3C per AWS A5.29, ASME SFA 5.29

### Characteristics:

- Basic slag provides low diffusible hydrogen and excellent CVN toughness.
- Meets the same requirements as E11018-M covered electrodes.
- Well suited for welding HSLA steels in the 110-130 Ksi tensile range.

### Applications:

Select 115-K3 produces weld metal with a minimum tensile strength of 110 Ksi, excellent low temperature CVN toughness and low diffusible hydrogen levels. These characteristics make 115K3 an ideal selection for welding high strength, low alloy steels such as T-1, ASTM A514 and HY-100; and for welding abrasion resistant steels in the 300, 350 and 400 series.

### Typical Mechanical Properties:

Ultimate Tensile Strength (psi)	116,000
Yield Strength (psi)	104,000
Percent Elongation	20
CVN (ft •lb f) @ -60° F	39

### Typical Deposit Composition:

<u>Wt%</u>	<u>C</u>	<u>Mn</u>	<u>Si</u>	<u>P</u>	<u>Ni</u>	<u>Mo</u>	<u>S</u>
	.04	1.64	.46	.010	2.01	.46	.010

### Suggested Welding Parameters:

<u>Diameter</u>	<u>Optimum</u>			<u>Range</u>	
	<u>Amperage</u>	<u>Voltage</u>	<u>WFS</u>	<u>Amperage</u>	<u>Voltage</u>
1/8"	475	28	115	375-650	26-36
3/32"	400	28	185	350-550	26-34
5/64"	370	28	250	280-500	26-33
1/16"	300	29	320	250-450	26-34
.045"	250	28	380	120-320	22-31

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**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. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.