Select 101-K3C

Low Alloy / Gas Shielded / Flux Cored

PRODUCT DATA SHEET

FEATURES

- Spray-like transfer with low spatter and good welder appeal
- Fast freezing slag facilitates welding in all positions
- Ideal for welding of HY-80, certain grades of A514, and HSLA-80 steels.
- Typical applications for these steels include crane fabrication, trailer construction, and other structural applications involving higher strength materials.

CONFORMANCES

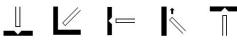
AWS A5.29 E101T1-K3C-H8 E101T1-K3C-JH8

ASME SFA 5.29 E101T1-K3C-H8

DIAMETERS (in (mm))

0.045 (1.2), 0.052 (1.3), 1/16 (1.6)

POSITIONS



SHIELDING GAS

100% CO2

Flow Rate: 40 - 50 CFM

POLARITY

Direct Current Electrode Positive (DCEP)

TYPICAL WELD DEPOSIT CHEMISTRY (WT%)

Shielding Gas	С	Cr	Mn	Мо	Ni	P	S	Si	V	
100%CO2	0.06	0.04	1.45	0.40	1.80	0.007	0.009	0.33	0.02	

TYPICAL MECHANICAL PROPERTIES

Shielding Gas	Tensile Strength ksi (MPa)	Yield Strength ksi (MPa)	Elongation (%)	Weld Condition	PWHT Temp	CVN @ 0°F (-20°C) ft-lb (J)	CVN @ -20°F (-30°C) ft-lb (J)
100%CO2	118 (813)	109 (754)	23	As-Welded	-	54 (73)	45 (61)



Revision: 9/26/2022

Notice: Be sure to follow all your employers safety practices, policies and procedures when using this product. Refer to CSA W117.2 and ANSI Z49.1 Safety in Welding, Cutting and Allied Processes for further information and the manufactures SDS sheet. 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.

RECOMMENDED WELDING PARAMETERS

Diameter in (mm)	Shielding Gas	Position	WFS* in/min (m/min)	Amps	Volts	CTWD* in (mm)
0.045 (1.2 mm)	100% CO2	All Positions	200 (5.1)	145	23	1/2 - 5/8 (13 - 16)
		All Positions	235 (6.0)	160	24	1/2 - 5/8 (13 - 16)
		All Positions	All Positions 300 (7.6) 185 26		26	1/2 - 5/8 (13 - 16)
		Flat & Horizontal 375 (9.5) 215 27		27	5/8 - 3/4 (16 - 19)	
		Flat & Horizontal	440 (11.2)	235	29	5/8 - 3/4 (16 - 19)
0.052 (1.3 mm)	100% CO2	All Positions	170 (4.3)	155	23	5/8 - 3/4 (16 - 19)
		All Positions	200 (5.1)	175	24	5/8 - 3/4 (16 - 19)
		All Positions	250 (6.4)	225	26	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	310 (7.9)	250	27	3/4 -1 (19 - 25)
		Flat & Horizontal	395 (10.0)	280	29	3/4 -1 (19 - 25)
1/16 (1.6 mm)		All Positions	125 (3.2)	165	23	5/8 - 3/4 (16 - 19)
	100% CO2	All Positions 150 (3.8) 195 24		24	5/8 - 3/4 (16 - 19)	
		All Positions 185 (4.7) 225 26		5/8 - 3/4 (16 - 19)		
		All Positions	All Positions 265 (6.7) 280 27		3/4 - 1 (19 - 25)	
		All Positions	325 (8.3)	320	29	3/4 - 1 (19 - 25)

^{*} WFS = Wire Feed Speed, CTWD = Contact Tip To Work Distance

PACKAGING (lbs (kgs))

33 (15) Spools, 60 (27.2) Coils, 500 (226.8) Round Drum, 800 (362.9) Hex Drum, 900 (408.2) Hex Drum

STORAGE AND HANDLING

All products should be stored in original packaging, in dry conditions and handled with care. For more information refer to our website.



Revision: 9/26/2022

Notice: Be sure to follow all your employers safety practices, policies and procedures when using this product. Refer to CSA W117.2 and ANSI Z49.1 Safety in Welding, Cutting and Allied Processes for further information and the manufactures SDS sheet. 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.

^{*}Some packaging options may not be available depending on diameter and product. Special package options may be available upon request.