

# Select 111-K3M

Low Alloy / Gas Shielded / Flux Cored

PRODUCT DATA SHEET

## FEATURES

- Intended for single and multiple pass welding of various high strength, low alloy steels in all positions.
- 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.

## CONFORMANCES

AWS A5.29

E111T1-K3M-JH4

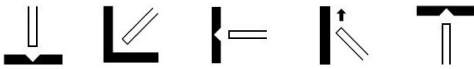
ASME SFA 5.29

E111T1-K3M-JH4

## DIAMETERS (in [mm])

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

## POSITIONS



## SHIELDING GAS

75-80%Ar/Balance CO2

Flow Rate: 40 - 50 CFH

## POLARITY

Direct Current Electrode Positive (DCEP)

## TYPICAL WELD DEPOSIT CHEMISTRY [WT%]

Shielding Gas	C	Cr	Mn	Mo	Ni	P	S	Si	V
75%Ar / 25%CO2	0.07	0.06	2.03	0.38	1.99	0.007	0.003	0.38	0.014

## TYPICAL MECHANICAL PROPERTIES

Shielding Gas	Tensile Strength ksi (MPa)	Yield Strength ksi (MPa)	Elongation (%)	Weld Condition	PWHT Temp	CVN @ -20°F (-30°C) ft-lb (J)	CVN @ -40°F (-40°C) ft-lb (J)
75%Ar / 25%CO2	120 (828)	108 (745)	20	As-Welded	-	47 (64)	38 (52)



Revision: 1/17/2025

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.

600 Enterprise Drive, P.O. Box 259, Fort Loramie, Ohio 45845-0259 • 800-341-5215 • [www.Select-Arc.com](http://www.Select-Arc.com)

## RECOMMENDED WELDING PARAMETERS \*\*

Diameter in (mm)	Shielding Gas	Position	WFS* in/min (m/min)	Amps	Volts	CTWD* in (mm)
0.045 (1.2 mm)	75% Ar/25% 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	300 (7.6)	185	25	1/2 - 5/8 (13 - 16)
		Flat & Horizontal	375 (9.5)	215	26	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	440 (11.2)	235	28	5/8 - 3/4 (16 - 19)
0.052 (1.3 mm)	75% Ar/25% 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	25	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	310 (7.9)	250	26	3/4 - 1 (19 - 25)
		Flat & Horizontal	395 (10.0)	280	28	3/4 - 1 (19 - 25)
1/16 (1.6 mm)	75% Ar/25% CO2	All Positions	125 (3.2)	165	23	5/8 - 3/4 (16 - 19)
		All Positions	150 (3.8)	195	24	5/8 - 3/4 (16 - 19)
		All Positions	180 (4.6)	225	25	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	265 (6.7)	280	26	3/4 - 1 (19 - 25)
		Flat & Horizontal	325 (8.3)	320	28	3/4 - 1 (19 - 25)

\* WFS = Wire Feed Speed, CTWD = Contact Tip To Work Distance

\*\*The parameters listed are recommended starting points of operation and the ranges for amperage, wfs, and voltage could be extended based on fitness for application. For products with "all-position" capability, as determined and listed in classification, the position recommendation can be determined based on operator skill and material thickness and isn't limited to the listing.

## APPROVALS

Agency	Approval	Shielding Gas	Diameter(s) in (mm)
ABS	E111T1-K3MJ	M21 (75%Ar / 25%CO2)	0.045 (1.2) - 1/16 (1.6)

## 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

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

## 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.



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.