

# Select 115-K4

Low Alloy / Gas Shielded / Flux Cored

PRODUCT DATA SHEET

## FEATURES

- The basic slag system provides better mechanical properties and lower diffusible hydrogen levels in the weld deposit than T-1 (rutile) slag systems.
- Arc transfer is globular and more spatter is produced than with T-1 slag systems.
- Select 115-K4 is an improved T-5 electrode with slag removal and bead geometry similar to that of E10018 electrodes
- Ideal for welding T-1, HY-100, ASTM A514, and other HSLA steels of similar strength.

## CONFORMANCES

AWS A5.29

E110T5-K4C

## DIAMETERS (in [mm])

0.045 (1.2), 1/16 (1.6), 3/32 (2.4)

## POSITIONS



## SHIELDING GAS

100% CO<sub>2</sub>

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
100%CO <sub>2</sub>	0.06	0.50	1.79	0.46	2.30	0.007	0.011	0.52	0.01

## TYPICAL MECHANICAL PROPERTIES

Shielding Gas	Tensile Strength ksi (MPa)	Yield Strength ksi (MPa)	Elongation (%)	Weld Condition	PWHT Temp	CVN @ -60°F (-50°C) ft-lb (J)
100%CO <sub>2</sub>	128 (880)	113 (779)	21	As-Welded	-	34 (46)



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	Flat & Horizontal	275 (7.0)	160	25	1/2 - 5/8 (13 - 16)
		Flat & Horizontal	350 (8.9)	190	27	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	435 (11.0)	220	29	5/8 - 3/4 (16 - 19)
1/16 (1.6 mm)	100% CO2	Flat & Horizontal	250 (6.4)	265	25	3/4 (19)
		Flat & Horizontal	280 (7.1)	290	27	3/4 - 1 (19 - 25)
		Flat & Horizontal	315 (8.0)	315	29	3/4 - 1 (19 - 25)
3/32 (2.4 mm)	100% CO2	Flat & Horizontal	145 (3.7)	320	25	1 (25)
		Flat & Horizontal	160 (4.1)	345	27	1 1/4 - 1 1/2 (32 - 38)
		Flat & Horizontal	170 (4.3)	370	29	1 1/4 - 1 1/2 (32 - 38)

\* 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.

## 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.



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