

Select 110C-K4

Low Alloy / Gas Shielded / Metal Cored

PRODUCT DATA SHEET

FEATURES

- Faster travel speeds, leading to increased productivity; enhanced width of fusion into sidewalls.
- An ideal choice for joining low alloy, high strength steels such as HY-100 and A514.
- Earthmoving equipment, mining trucks and machinery, and heavy equipment trailers are some areas where these steels may be utilized.
- This electrode may also be used for overlay or surfacing in certain applications.
- As with all higher strength filler metals, care must be taken to maintain proper heat input, interpass temperatures, and welding parameters

CONFORMANCES

AWS A5.28	E110C-K4-H4
AWS A5.36	E110T15-M20A6-K4-H4 E110T15-M21A6-K4-H4
ASME SFA 5.28	E110C-K4-H4

DIAMETERS (in [mm])

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

POSITIONS



SHIELDING GAS

Ar + 5-25% CO₂, Ar + 2% O₂

Flow Rate: 40 - 50 CFM

POLARITY

Direct Current Electrode Positive (DCEP)

TYPICAL WELD DEPOSIT CHEMISTRY (WT%)

Shielding Gas	C	Cr	Cu	Mn	Mo	Ni	P	S	Si	V
75%Ar / 25%CO ₂	0.03	0.48	0.06	1.77	0.48	2.16	0.007	0.009	0.66	0.004
92%Ar / 8%CO ₂	0.06	0.51	0.05	1.98	0.52	2.15	0.008	0.011	0.62	0.006

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)
75%Ar / 25%CO ₂	117 (807)	103 (710)	22	As-Welded	-	35 (47)
92%Ar / 8%CO ₂	119 (821)	104 (717)	18	As-Welded	-	26 (35)



Revision: 9/14/2022

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.

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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	Flat & Horizontal	260 (6.6)	200	25	1/2 - 5/8 (13 - 16)
		Flat & Horizontal	305 (7.7)	220	26	1/2 - 5/8 (13 - 16)
		Flat & Horizontal	360 (9.1)	240	27.5	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	405 (10.3)	255	29	5/8 - 3/4 (16 - 19)
0.052 (1.3 mm)	75% Ar/25% CO2	Flat & Horizontal	235 (6.0)	215	25	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	315 (8.0)	260	26	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	330 (8.4)	275	27.5	3/4 - 1 (19 - 25)
		Flat & Horizontal	345 (8.8)	295	29	3/4 - 1 (19 - 25)
1/16 (1.6 mm)	75% Ar/25% CO2	Flat & Horizontal	200 (5.1)	250	25	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	245 (6.2)	290	26	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	275 (7.0)	310	27.5	3/4 - 1 (19 - 25)
		Flat & Horizontal	285 (7.2)	330	29	3/4 - 1 (19 - 25)

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

Welding parameters are for 75% Ar /25% CO2, at higher levels of argon the voltage should be gradually decreased: ½-1 volt for 85% Ar/15% CO2, 1-1 ½ volts for 90% Ar/10% CO2, and 1-2 volts for 95% Ar/5% CO2 & 98% Ar/2% O2.

APPROVALS

Agency	Approval	Shielding Gas	Diameter(s) in (mm)
CWB CSA W48-23	E760T15-M21A5-K4-H4 (E76C-K4-H4)	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.



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