

K-110TK3

AWS E110T1-K3

FOR HIGH TENSILE
STRENGTH STEEL

Typical applications

K-110TK3 is a flux cored wire that is compared to a low alloy E11018M electrode but with higher deposition rates. It is well suited for joining high tensile steels that will be used a low temperature environment (ASTM A514; A517; A710, JIS G 3128 SHY, HY-80 Grade)

Characteristics on Usage

- ① Wire is a titania type of flux cored wire for all-position welding.
- ② The weld metal contains about 2.0%Ni and has good impact value at low temperatures.
- ③ In case of heavy plate welding, preheat at 50~150°C.
- ④ The shielding gas should be used 100% CO₂ for welding.
- ⑤ Refer to page 150 for more information on usage.

Typical chemical composition of all-weld-metal (%)

Shielding Gas	C	Si	Mn	P	S	Ni	Mo
CO ₂	0.04	0.51	1.72	0.014	0.012	2.04	0.42

Typical mechanical properties of all-weld-metal

Shielding Gas	Y · P	T · S	EI	Charpy V-notch
	N/mm ² {kgf/mm ² }	N/mm ² {kgf/mm ² }	(%)	J {kgf · m} (-20°C)
CO ₂	751 {77}	834 {85}	21	80 {8}

Sizes available and recommended currents (DC wire⊕)

Dia.	(mm)	1.2	1.6
Amp.	F	160~360	200~460
	H-Fil		
	V		

Package

Dia.	(mm)	1.2	1.4	1.6
Spool	(kg)	5, 12.5, 15, 20		

Welding positions



Approved by

ABS, CWB