

TYPE : Rutile

## Applications

Supercored 110 is suitable for single or multipass welding for high strength low alloy steel.

## Characteristics on Usage

Supercored 110 is titania type of flux cored wire for all position welding. It provides excellent impact values at low temperature.

## Notes on Usage

- ① Proper preheating(50~150°C) (122~302°F) and inter-pass temperature must be used in order to release hydrogen which may cause cracking in weld metal when electrodes are used for medium and heavy plates.
- ② One-side welding defects such as hot cracking that may occur with wrong welding parameter such as high welding speed.
- ③ Use 100% CO<sub>2</sub> gas.

## Welding Position

## Current

## Shielding Gas



1G (PA)   2F (PB)   3G (PF)   4G (PE)

DC +

CO<sub>2</sub>

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni	Mo
0.06	0.35	1.55	0.016	0.007	2.20	0.50

## Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
780 (113,000)	830 (121,000)	19.9	-40 (-40)	60 (44)

## Approval

## I Packing

ABS	Dia. (mm) (in)	1.2 .045	Spool(kg) (lbs)	12.5	15	20
				28	33	44

## Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.2 (.045)
F & HF	120~300
V-up,OH	120~260
V-down	180~280