

GFC 111K3

IDENTIFICATION

GFC 111K3, E 111T1 - K3C

CLASSIFICATION

AWS/SFA 5.29: E111T1-K3C,
JIS Z3313 T762T1-1MA-N3M2 H5

DESCRIPTION

- Wire is a Titania type of flux cored wire for all-position welding.
- It provides smooth arc, low spatter levels, good weldability and good bead appearance.
- It provides excellent impact values at low temperature.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Ni	Mo
0.15 max	2.25 max	0.36 max	0.005 max	0.011 max	1.5 - 2.6	0.65 max

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
802 min	767 min	20 min	-20°C	114

TYPICAL APPLICATIONS

- GFC 111K3 is designed for welding of 760 MPa high tensile steel with outstanding mechanical properties.
- The typical applications include high tensile steels that will be used a low temperature environment.

DIFFUSIBLE HYDROGEN IN THE WELD METAL : max 5ml/100g of weld metal.

NOTES ON USAGE

- Proper preheating (50-150° C) and interpass temperature must be used in order to release diffusible hydrogen which may cause cracking in weld metal when electrodes are used for medium and heavy plates.
- Gas flow rate is proper 20-25 l/mm.
- Shielding gas should be used 100% CO2 or Ar + 20 - 25% CO2

PACKING PARAMETERS

Size (mm)	Amps DC (+)			Weight / Spool (kg)
	F	HF	V - up, OH	
1.2	150 - 340	150 - 340	120 - 260	12.5