

GFC 115-K4

IDENTIFICATION

GFC 115-K4, E110T5-K4M

CLASSIFICATION

AWS/A 5.29: E110T5-K4M

DESCRIPTION

GFC 115-K4 is basic flux cored wire for the welding of high-strength fine grain structural steels.

Operating

features include low spatter loss, easy slag removal and uniform bead appearance.

MATERIALS : S620, S690, HY 100.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	Cr	Ni	Mo	P
0.15 max	1.20 - 2.25	0.8 min	0.03 max	0.2 - 0.6	1.75 - 2.60	0.3 - 0.65	0.03

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
760 - 900	≥ 690	≥ 17	- 51°C	≥ 60

TYPICAL APPLICATIONS

- 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/min.
- Shielding gas should be used Ar + 20-25% CO2

CURRENT CONDITION : DC +

PACKING PARAMETERS

Size (mm)	Weight / Spool / Kg
1.2	12.5