

Flux Cored Wire

GMX 111-K3

AWS A5.29 E111T1-K3C / AWS A5.29M E761T1-K3C
ISO 18276-B-T762T1-1CA-N3M2

Description and Applications:

- GMX111-K3 is a rutile type flux cored wire designed for single and multi pass welding of high strength low alloy steels. The arc is smooth with less spatters. The deposited metal owns typical 2.0%Ni-0.5%Mo alloy makes it suitable for general purpose use.

Guideline in Usage:

- The diameters up to 1.6mm are capable of being welded out-of-position.
- Base metal should be preheated.

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

C	Si	Mn	P	S	Ni	Cr	Mo
0.04	0.45	1.71	0.016	0.008	2.10	0.05	0.59

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (-20°C) J
819	841	17	55

Size (mm) & recommended welding parameters

Diameter		1.2	1.6
Polarity		DC+	DC+
Ampere (A)	Flat, horizontal position	180~300	200~350
	Vertical / overhead position	120~300	-
Shielding Gas		CO2	CO2

Note:

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