



METALLOY[®] 110

GAS-SHIELDED METAL-CORED WIRE
AWS E110C-K4

080623 (replaces 080519)

Metalloy 110 is a gas shielded metal-cored wire that is designed for the single- and multi-pass welding of high strength steels including quench and tempered high strength steels such as A514 (T1), HY80 and HY100. Metalloy 110 can also be used for other high strength applications such as welding castings, heavy equipment and shipbuilding fabrication and repair. Metalloy 110 is designed for use with 75% Ar/25% CO₂, and 90% Ar/10% CO₂.

PRODUCT CHARACTERISTICS:

- Virtually no spatter
- Single or multi-pass welding of high strength low alloy steels.
- Higher deposition rates compared to solid wire.
- Recommended for welding quenched and tempered HSLA steels.

SPECIFICATIONS:

E110C-K4 per AWS A5.28
CWB E110C-G H4

SHIELDING GAS:

75% Ar/25% CO₂, 90% Ar/10% CO₂ 35-50 cfh

WELDING POSITIONS:

CV Spray - flat, horizontal, vertical down
Pulse and short arc. - all positions

STANDARD DIAMETERS:

.045", 1/16"

TYPICAL UNDILUTED WELD METAL CHEMISTRY*:

C	Mn	Si	Ni	Cr	Mo
0.08	1.44	0.43	2.32	0.23	0.47

TYPICAL MECHANICAL PROPERTIES*:

	75% Ar/25% CO ₂	90% Ar/10% CO ₂
Tensile Strength	124,800 psi (860 MPa)	118,100 (814 MPa)
Yield Strength	105,200 psi (725 MPa)	109,400 (754 MPa)
Elongation	15.2%	22.2%
CVN @-60°F (-51°C)	40 ft•lbs (54 J)	28 ft•lbs (38 J)

Other shielding gas may be used, but must be agreed upon by supplier and purchaser.

The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Hobart Brothers Company expressly disclaims any liability incurred from any reliance thereon. Typical data is obtained when welded and tested in accordance with AWS A5.28 specifications. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique not controlled by Hobart Brothers Company.

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RECOMMENDED OPERATING PARAMETERS:

The information below was determined by welding performed with 75% Ar/25% CO₂ shielding gas at a flow rate of 35 cfh.

Diameter	Arc Voltage (volts)	Current DCEP (+) (amps)	Approx. Wire Feed Speed (in/min)	Deposition Rate (lbs/hr)
.045"	27	200	235	6.0
	32	300	455	10.8
	35	400	680	18.6
1/16"	28	300	255	11.2
	32	400	390	17.6
	34	450	465	20.9

Notice:

Actual use of the product may produce varying results due to conditions and welding techniques over which Tri-Mark has no control, including, but not limited to, plate chemistry, weldment design, fabrication methods, electrode size, welding procedure, service requirements and environment. The purchaser is solely responsible for determining the suitability of Tri-Mark products for the purchaser's own use. Any prior representations shall not be binding. Tri-Mark disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.

Caution:

Consumers should be thoroughly familiar with the safety precautions shown on the Warning Label posted on each shipment in and in American National Standard Z49.1, "Safety in Welding and Cutting," published by the American Welding Society, 550 NW LeJeune Road, Miami, FL 33126, and OSHA Safety and Health Standards 29 CFR 1910, available from the U.S. Department of Labor, Washington, D.C. 20210.