

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% CO₂ gas.

Welding Position



1G 2F 3G 4G
(PA) (PB) (PF) (PE)

Current

DC +

Shielding Gas

CO₂

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

Approval

ABS

I Packing

Dia. (mm) 1.2
(in) .045

Spool(kg) 12.5 15 20
(lbs) 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