

XP 110-MC (Seamless)

HIGH STRENGTH



CLASSIFICATIONS

| EN ISO 18276-A | AWS A5.28 |
|---------------------------|-------------|
| T 69 4 Mn2NiMo M M21 1 H5 | E110C-K4 H4 |

KEY FEATURES AND APPLICATIONS

- Seamless metal cored wire capable of producing welds with a tensile strength of ≥ 690 MPa.
- Suitable for single and multiple pass welding of high strength steels.
- Typical diffusible hydrogen content is < 3.0 ml 100 g. Guaranteed for the total processing time < 4.0 ml 100 g.
- Excellent mechanical properties at subfreezing temperatures down to -40°C .
- Widespread usage across diverse industries, including shipbuilding, steel and tank construction, mechanical engineering and pipeline construction, offshore, crane construction, lifting equipment and platforms.

BASE MATERIALS

S500QL - S690QL, N-A-Xtra70, Weldox 700, HY80, HY100, T1, Superelso 700, Suprafort 700, Shoralsim 690

CHEMICAL COMPOSITION OF WIRE %

| | C | Mn | Si | P | S | Ni | Cr | Mo |
|-----|------|-----|-----|-------|-------|-----|-----|-----|
| MIN | 0.03 | 1.4 | - | - | - | 1.8 | - | 0.3 |
| MAX | 0.10 | 2.0 | 0.9 | 0.020 | 0.020 | 2.6 | 0.2 | 0.7 |

Single values are maximum values according to EN ISO 18276

MECHANICAL PROPERTIES OF ALL-WELD METAL - TYPICAL (MIN.) VALUES

| Yield Strength (MPa) | Tensile Strength (MPa) | Elongation (%) | Impact ISO-V (J) | Test Temperature |
|----------------------|------------------------|------------------|------------------|-----------------------|
| 760 (≥ 690) | 820 (770 - 940) | 19 (≥ 17) | 75 (≥ 47) | -40°C |

Test data for mechanical properties are not guaranteed since actual as welded conditions depend on numerous variables

OPERATING DATA

| Shielding Gases | Polarity |
|--------------------|----------|
| EN ISO 14175 - M21 | DC+ |

WELDING PARAMETERS

| Diameter (mm) | Current (A) | Voltage (V) |
|---------------|-------------|-------------|
| 1.2mm | 90 - 300 | 14 - 32 |

PACKAGING AND AVAILABLE SIZES

| Part Number | Diameter (mm) | Spool | Weight (kg) | Pallet Qty |
|-------------|---------------|-------|-------------|------------|
| XP15424 | 1.2 | BS300 | 16 | 64 |