

XP 111-RC (Seamless)

HIGH STRENGTH



CLASSIFICATIONS

EN ISO 18276-A	AWS A5.29
T 69 4 Mn2NiMo P M21 1 H5	E111T1-K3M H4

KEY FEATURES AND APPLICATIONS

- Seamless rutile flux cored wire for welding steel grades like S690.
- 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

P690QH - P500Q - P690Q - P500QL1 - P690QL1 - S550Q - S620Q - S690Q - S650QL - S620QL - S690QL - L555QB - L555MB - (X80)

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	180 - 300	22 - 32

PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Spool	Weight (kg)	Pallet Qty
XP15430	1.2	BS300	16	64