



Elgacore MXX 100

FCAW - Flux cored arc welding
Un-alloyed

Date:	2013-05-27
Revision:	12

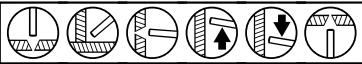
Description:

Elgacore MXX 100 is a fully positional metal cored wire for use with Ar/CO₂ or CO₂ shielding gas. Specially designed for manual or mechanised welding of thinner and medium thick material. Excellent welding characteristics with a spatter-free arc, producing little slag and offering good resistance to porosity. Elgacore MXX 100 combines ease of use, high productivity and good mechanical properties down to -30 °C. Superior wire feeding and a weld hydrogen content less than 5 ml/100g. Suitable for welding mild and medium strength carbon manganese structural steels.

Applications:

Applications include general fabrication, structural steelwork, bridge building and shipbuilding.

Welding positions:



Welding current:

DC+

Deposition efficiency:

96%

Shielding gas:

M21, 80% Ar + 20% CO₂, 22-25 l/min
C1, CO₂, 22-25 l/min

Stick-out:

15-25 mm

Hydrogen content / 100 g weld metal

≤ 5 ml

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min							
Typical	0,07	0,5	1,5	0.015	0.014		
Max	0.12	0.90	1.75	0.03	0.03	0.20	0.50

	Mo	Cu	V	Nb
Min				
Typical				
Max	0.20	0.30	0.08	0.05

Mechanical properties

	Specified	Typical
Yield strength, Re:	≥ 420 MPa	450 MPa
Tensile Strength, Rm:	500-640 MPa	570 MPa
Elongation, A5	≥ 22%	29%
Impact energy, CV:	-20 °C • 47 J	-20 °C • 100 J -30 °C • 75 J

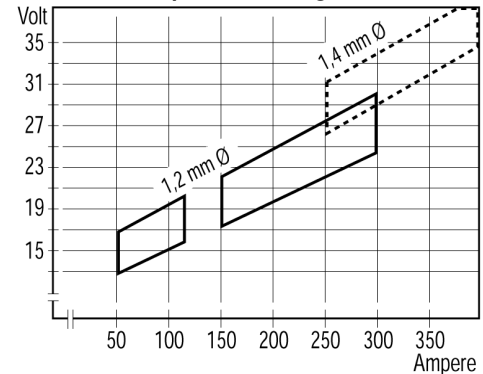
Classification:

EN 758	T 42 2 M C/M 1 H5
AWS A5.18	E 70C-6M/-6C
ISO 17632-A	T 42 2 M C/M 1 H5

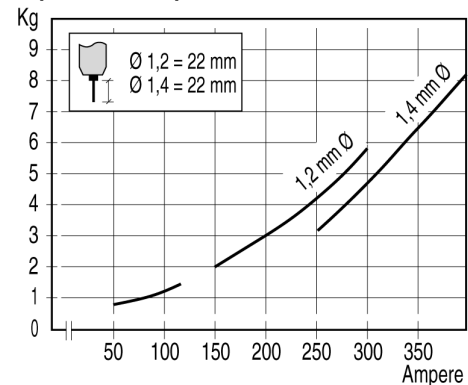
Approvals:

DNV	III YMS H5
GL	3YH5S
LR	3Y,3YS H5
DB	042.42.12
TÜV	09774.00
CE	

Recommended parameter range:



Deposition rate per hour:



Product data:

Diam.mm	Product code	Spool weight
1,2	95551012	15 kg BS300
1,2	95552112	5 kg D200
1,2	95552212	250 kg ProPac
1,4	95551014	15 kg BS300
1,4	95552214	250 kg ProPac

Note

Strip:
S ≤ 0.015%
P ≤ 0.025%
N ≤ 0.004%

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