



# Elgacore MXA 100XP

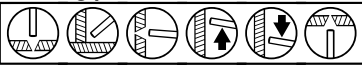
FCAW - Flux cored arc welding  
Un-alloyed

Date: 2013-05-27  
Revision: 8

## Description:

Elgacore MXA 100XP is a highly versatile metal cored wire for use with an Ar/CO<sub>2</sub> gas shield, designed for high productivity manual or mechanised welding. It is fully positional, including exceptionally good vertical down operability using negative polarity. For all other positions, apart from vertical down, either DC - or DC + may be employed with equally good stable, low spatter arc characteristics. Elgacore MXA 100XP has good fracture toughness down to -40°C and with its superior wire feeding and weld hydrogen content less than 5 ml/g is ideal for general fabrication, structural steelwork and shipbuilding.

## Welding positions:



## Welding current:

DC- / DC+

## Deposition efficiency:

96%

## Shielding gas:

M21, 80% Ar + 20% CO<sub>2</sub>, 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	0.45	1.45	0.010	0.010		
Max	0.12	0.90	1.75	0.030	0.030	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:	≥ 460 MPa	485 MPa
Tensile Strength, Rm:	530-680 MPa	580 MPa
Elongation, A5	≥ 20%	27%
Impact energy, CV:	-40°C • 47 J	-40°C • 110J

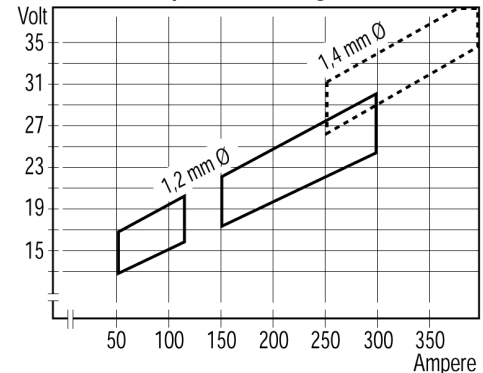
## Classification:

EN 758	T 46 4 M M 1 H5
AWS A5.18	E 70C-6M
ISO 17632-A	T 46 4 M M 1 H5

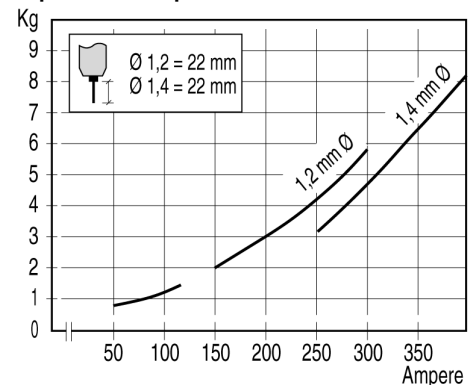
## Approvals:

DNV	IV Y42 H5
LR	4Y42 H5
GL	4Y 40 H5S
TÜV	10770.00
CE	

## Recommended parameter range:



## Deposition rate per hour:



## Product data:

Diam.mm	Product code	Spool weight
1,2	95671012	15 kg BS300
1,2	95671112	5 kg BS200
1,2	95672112	5 kg D200
1,2	95672212	250 kg ProPac
1,4	95671014	15 kg BS300
1,4	95672214	250 kg ProPac

## Note

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

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