



Elgacore MX 200E

FCAW - Flux cored arc welding
Un-alloyed

Date:	2009-02-19
Revision:	4

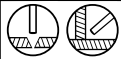
Description:

Elgacore MX 200E is a rutile flux cored wire for use with a CO₂ gas shield. It has a relatively high iron powder content and is specially designed for high speed fillet welding of plate coated with modern inorganic zinc primers. The wire operates with a very stable arc to produce a slightly convex fillet profile, smooth bead surface, minimum spatter and excellent slag detachability. The combination of high deposition efficiency and excellent resistance to porosity at high travel speeds makes Elgacore MX 200E ideal for mechanised welding of standing fillets.

Applications:

Panel lines, bulb bares

Welding positions:



Welding current:

DC+

Deposition efficiency:

89%

Shielding gas:

C1, 100% 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	0,05	0,6	1,6				
Max	0,12	0,90	1,75	0,03	0,03	0,20	0,50

	Mo	Cu	V
Min			
Typical			
Max	0,20	0,30	0,08

Mechanical properties

	Specified	Typical
Yield strength, Re:	≥ 420 MPa	535 MPa
Tensile Strength, Rm:	500-640 MPa	595 MPa
Elongation, A5	≥ 20%	30%
Impact energy, CV:	-30°C • 47 J	-30°C • 65 J

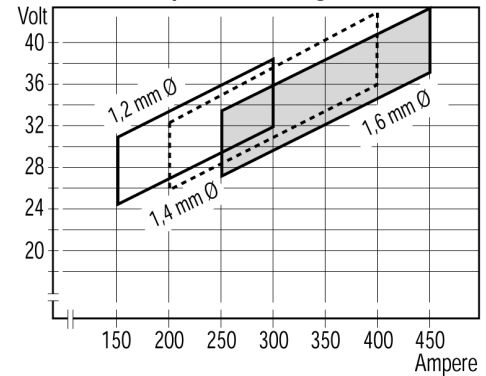
Classification:

EN 758	T 42 3 R C 3 H5
AWS A5.20	E 70T-9
ISO 17632-A	T 42 3 R C 3 H5

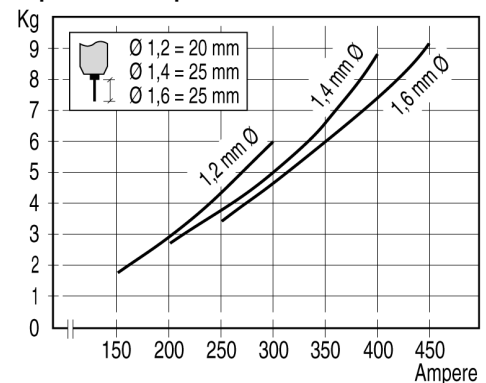
Approvals:

GL	4Y40H5S
DNV	IV Y40MS H5
LR	4Y40S H5
ABS	2Y400SA H5
MRS	4Y42MSH5

Recommended parameter range:



Deposition rate per hour:



Product data:

Diam.mm	Product code	Spool weight
1,2	95691012	15 kg BS300
1,4	95691014	15 kg BS300

Note

Strip:
S ≤ 0.03%
P ≤ 0.03%
N ≤ 0.004%