

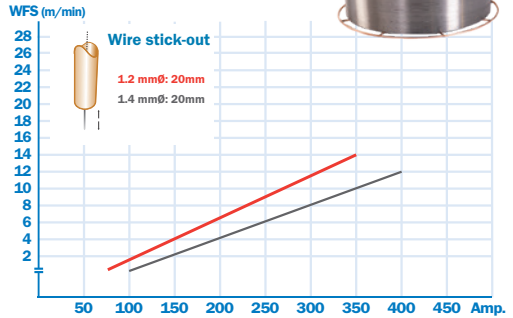
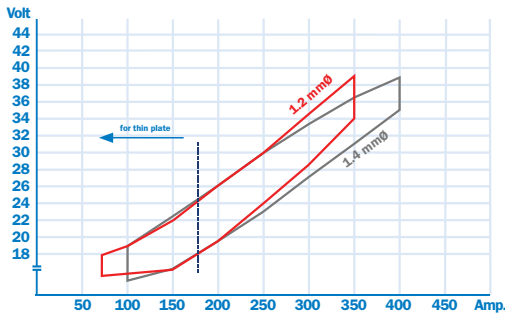
Description and Application

MX-100T is an all positional metal cored wire. Thanks to its excellent arc re-striking characteristics combined with excellent wire feeding properties, this wire is very well suited for welding thin plates.

This wire is especially well suited for root passes without ceramic backing, for example in pipeline construction, which leads to significant increases in productivity when compared to the TIG or stick electrode process.



Recommended Parameter Range, for flat position*



* The above values and parameters are for all weld metal produced using 100%CO₂ shielding gas

Typical Chemical Analysis (wt. %)

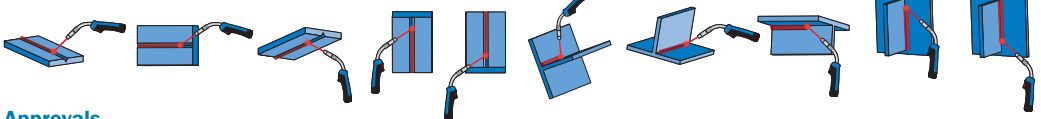
Shielding gas	C	Si	Mn	P	S	Ni	Cr	Mo
100%CO ₂	0.08	0.49	1.53	0.013	0.015	-	-	-
80%Ar-20%CO ₂	0.07	0.61	1.75	0.011	0.014	-	-	-

Typical Mechanical Properties

Shielding gas	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)-20°C	CV(J)-30°C
100%CO ₂	480	560	31	71	62
80%Ar-20%CO ₂	500	605	28	73	65
Guaranty	min.420	500-640	min.20	min.47	min.27

Example of Diffusible hydrogen content: 3.0 [ml/100g] CO₂, 3.5 [ml/100g] 80%Ar-20%CO₂

Welding Positions



Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
3YS H5	IIIYMS H5	SA3YM HHH	3SA, 3YSA H5(C1)	3Y40MS H5	TUV, DB, CE