



Tru-Core[®] MC 110C-K4 AWS E110C-K4 H4

DESCRIPTION

Tru-Core[®] MC 110C-K4 is a low alloy steel, metal cored electrode for gas shielded arc welding of low alloy, and carbon steels requiring tensile strengths in excess of 110 ksi and good CVN values at temperatures as low as -60°F. This electrode is intended to be used with shielding gas blends of 75-95% Argon/Balance Carbon Dioxide. The MC 110C-K4 can be used in single and multiple pass applications, both in fillets and groove welds.

CHARACTERISTICS

PRODUCT FEATURES:

- Excellent mechanical properties
- Nearly slag free welds
- Flat bead geometry
- Smooth arc transfer
- Easy clean-up Excellent feedability
- Good low-temperature CVN properties
- Better sidewall fusion than solid electrodes

PRODUCED IN: Stillwater, Oklahoma

SPECIFICATIONS

Meets or exceeds:

- AWS A5.28: E110C-K4 H4
- ASME SFA 5.28: E110C-K4 H4

APPLICATIONS

Tru-Core[®] MC 110C-K4 is a good choice to weld steels from ¼" thickness up to heavy plates sections. Typical grades: ASTM A514 Grades, HY-100, and armor plate. Some examples are:

- Crane frames and components
- Mining machinery frames
- Construction equipment frames
- Welding armor to carbon steel and itself

SHIELDING GAS BLENDS

Typical Application Shielding Gas Blends:

- 75-95% Argon/Balance CO₂
- Flow Rate: 35-45 CFH

WELDING POSITIONS

All position welding is possible when using the correct shielding gas blends, welding process and welding parameters.

STORAGE

Welding wire should be stored in a dry, enclosed environment and in its originally-sealed package.

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