



ALLOYCRAFT 90 – Hermetically Sealed



TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

0.2% Proof Stress	590 MPa.
Tensile Strength	680 MPa.
Elongation	26%.
CVN Impact Values	90 J av @ -40°C.

TYPICAL ALL WELD METAL ANALYSIS:

C: 0.07%	Mn: 1.0%	Si: 0.40%
Ni: 1.6%	Mo: 0.3%	

TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

3.0 - 3.5 mls of hydrogen / 100gms of deposited weld metal.

COMPARABLE CIGWELD PRODUCTS

Verti-cor 91 K2
AWS A5.20: E91T1-K2.
Autocraft NiCrMo

- ▲ Hermetically Sealed Cans.
- ▲ Improved High Strength, Low Alloy Steel Electrode.
- ▲ Very Low "H5/H4" Diffusible Hydrogen Class.
- ▲ 620 MPa Tensile Class, Reliable Impact Toughness to -40°C.
- ▲ BATCH NUMBERED for On-the-Job Traceability.
- ▲ Applications include the full or under matching strength welding of high strength steels, including Bisalloy 60, 70 and 80, Welten 60 and 80, AS2074 Gr L6, Comsteel 023/026. ASTM A514 and A517 used in structural, transport, mining and earthmoving applications.

Classifications:

AS/NZS 1553.2:	E6218-M.
AWS/ASME-SFA A5.5:	E9018M H4.

Packaging and Operating Data:

AC (minimum 70 O.C.V.), DC+ or DC- polarity.

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Can	Carton	Part No
3.2	380	18	110 – 145	3kg	9kg – 3 x 3kg	611873
4.0	380	12	140 – 200	3kg	9kg – 3 x 3kg	611874
5.0	450	10	190 – 270	3kg	9kg – 3 x 3kg	611875

- Alloycraft 90 is formulated to operate with AC (min 70 O.C.V.), DC+ or DC- polarity. The preferred polarity for DC welding is DC+.

ALLOYCRAFT 110 – Hermetically Sealed



TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

0.2% Proof Stress	710 MPa.
Tensile Strength	820 MPa.
Elongation.	22%.
CVN Impact Values.	60 J av @ -50°C.

TYPICAL ALL WELD METAL ANALYSIS:

C: 0.07%	Mn: 1.5%	Si: 0.45%
Ni: 2.1%	Mo: 0.4%	Cr: 0.2%

TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

3.0 - 3.5 mls of hydrogen / 100gms of deposited weld metal.

COMPARABLE CIGWELD PRODUCTS:

Tensi-cor 110 TXP Verticor 111K3
AWS A5.20: E110T5-K4 AWS A5.20: E111T1-K3

- ▲ Hermetically Sealed Cans.
- ▲ Improved High Strength, Low Alloy Steel Electrode.
- ▲ Very Low "H5/H4" Diffusible Hydrogen Class.
- ▲ 760 MPa Tensile Class, Reliable Impact Toughness to -40°C.
- ▲ BATCH NUMBERED for On-the-Job Traceability.
- ▲ Applications include the full strength welding of high strength steels, including Bisalloy 80, USST1 and T1A, welten 80, HY80, AS2074 Grade L6A and ASTM A533 type A, A514 and A517 grades used in structural transport, mining and earthmoving applications.

Classifications:

AS/NZS 1553.2:	E7618-M.
AWS/ASME-SFA A5.5:	E11018M H4.

Packaging and Operating Data:

AC (minimum 70 O.C.V.), DC+ or DC- polarity.

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Can	Carton	Part No
3.2	380	18	110 – 145	3kg	9kg – 3 x 3kg	611893
4.0	380	12	140 – 200	3kg	9kg – 3 x 3kg	611894

- Alloycraft 110 is formulated to operate with AC (min 70 O.C.V.), DC+ or DC- polarity. The preferred polarity for DC welding is DC+.