



# ESSEN TUB 110T1 K4

**Classification:** AWS A5.29:2010 E110T1-K4C-M / ASME SFA5.29 E110T1-K4C-M

**Rutile flux-cored wire.**

The low-alloy rutile flux-cored wire, Essen TUB 110T1 K4, is specifically designed for joining high-strength steels, even under low-temperature conditions, providing excellent resistance to cracking and impact.

This wire stands out for its high deposition rate, stable arc, and ability to deliver a high-quality weld bead finish. With low spatter levels, it is specially developed for welding fine-grain, quenched and tempered high-strength steels, such as USS T1 and other similar steels.

## CHEMICAL COMPOSITION:

C	Mn	Si	P	S	Ni	V	Cr	Mo
0,15% Max.	1,20 to 2,25%	0,8% Max.	0,03% Max.	0,03% Max.	1,75 to 2,60%	0,030% Max.	0,20 to 0,60%	0,20 to 0,65%

## MECHANICAL PROPERTIES:

TENSILE STRENGTH:	YIELD STRENGTH:	ELONGATION:	CHARPY TEST
760 to 900 MPa	680 MPa (Min.)	15% (min)	27J to -20°C (Min.)

SHIELDING GAS:	CURRENT TYPE	STICK-OUT (mm):
CO2 100%	DC+	15 to 20

## PRODUCT FEATURES:

DIAMETER (mm):	CURRENT (A):	VOLTAGE (V):	PACKAGING (kg):
1.20	120 to 250	18 to 28	12.5
1.60	180 to 350	26 to 31	12.5

**NOTE:** AWS A5.36 was removed from Sections II-C and IX of the 2021 edition. Uniweld has not made any chemical or technical changes to the product due to the new classification.

### CUSTOMER SERVICE POLICY

The information provided above is for reference purposes only and shall not be considered as a guarantee or certificate. Many variables may influence the results of a welding operation. Uniweld Industria de Eletrodos LTDA assumes no responsibility for any incorrect application of the product. If you have any questions, we recommend contacting our Technical Assistance Department for proper support.