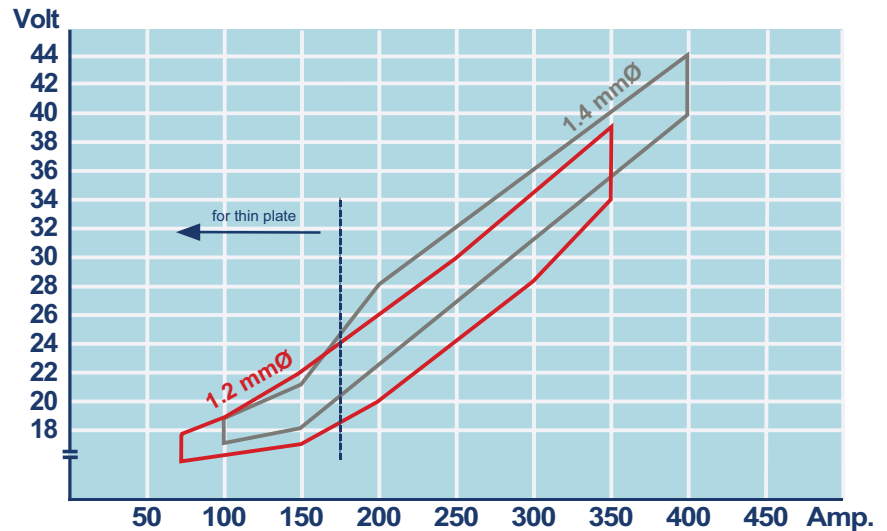


Description and Application

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



Note: The above parameter ranges are intended for Ar+CO₂. More voltage is necessary for 100% CO₂.

Chemical Analysis (wt.%)

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

Mechanical Properties

	R _e (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	CV (J) -20°C	CV (J) -30°C	Shielding gas
MX-100T	480	560	31	71	62	100%CO ₂
	500	605	28	73	65	80%Ar-20%CO ₂

Welding Positions

MX-100T
1.2, 1.4mm



Approvals

	LR	DNV	BV	GL	ABS	R.M.R.S.	Others
MX-100T	3S,3YS	IIIYMS	SA3YM	3YS	3SA,3YSA	3Y40MS	TÜV,DB