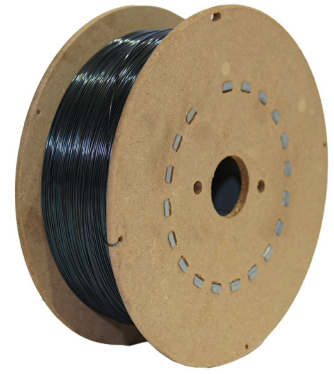


Tru-Core® MC 110C-K4 Metal-Cored Welding Wire

AWS E110C-K4 H4



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 exceeding 110 ksi and excellent CVN values, even in freezing temperatures as low as -60°F. It is suitable for both single and multiple pass applications with fillet or groove welds.

Its feedability contributes to a seamless welding process while its ability to produce nearly slag-free welds results in clean finishes. It can achieve flat bead geometry to create precise and visually appealing welds while offering a smooth arc transfer.

100% Made in the U.S.A. with American steel to meet "Buy America" Standards.

Manufacturing Advantages

- Welding steels from ¼" thickness up to heavy plates sections
- Typically used on grades ASTM A514 Grades, HY-100, and armor plate
- Lower diffusible hydrogen content for reduced risk of hydrogen-induced cracking
- Lower heat input during welding for minimal risk of distortion or warping
- Provides deep penetration for welding thick materials
- High deposition efficiency for increased productivity and faster welding

Welding Positions

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

Shielding Gas Blends

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


Applications

- Agricultural Equipment
- Auto Body
- Automotive Exhaust
- General Fabrication
- Heavy Equipment
- Pressure Vessels
- Shipbuilding
- Structural Steel
- Structures
- Railcars

Specifications

Meets or Exceeds:

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

 Made in the USA

Storage

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

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Typical Weld Metal Composition (as required per AWS)

	C	Mn	Si	P	S	Cu	Ni	Cr	Mo	V
95% Ar/5% O ₂	0.04	1.67	0.43	0.008	0.01	0.04	2.21	0.34	0.46	0
AWS/ASME	0.15 (max.)	0.75-2.25	0.80 (max.)	0.025 (max.)	0.025 (max.)	0.35 (max.)	0.50-2.50	0.15-0.65	0.25-0.65	0.03 (max.)

Typical Mechanical Properties (as welded)

	TENSILE STRENGTH KSI	YIELD STRENGTH KSI	ELONGATION (% IN 2")	CVN @ -20° F (-29°C)
90% Ar/10% CO ₂	111.7	101	18	26.7 ft-lbf
AWS/ASME	110 (min.)	98 (min.)	15 (min.)	20 (min.)

Typical Diffusible Hydrogen (ml/100g)

90% Ar/10% CO ₂	1.78
AWS/ASME	4.0 (max.)



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