

SAIW 100CK3

GB/T 17493 E69C-K3
AWS A5.36 E100T15-M21A6-K3

Characteristics: SAIW 100CK3 is a metal-cored wire for Ar+25%CO₂ mixed gas shielded welding. It is suitable for flat position welding. It has extremely high deposition efficiency, low spatter, and beautiful bead shape and profile. In addition, there is no need to clean the slag after welding.

Application: Suitable for structural welding of 700MPa grade high strength steel.

Wire dimension and package

Wire diameter	Package specification	Weight per tray
1.2mm	15kg/vinyl disc	1080kg

Recommended welding specifications

Welding current(A)	Arc voltage(V)	Pre-heat temperature(°C)	Interlayer temperature(°C)	Weldingspeed (mm/min)	Post-welded heat treatment
180~250	28~35	--	≤100	300~400	--

Chemical composition of deposited metal

Element (wt%)	C	Mn	Si	P	S	Cr	Ni	Mo
Standard value	≤0.15	0.75-2.25	≤0.80	≤0.025	≤0.025	≤0.15	0.5-2.5	0.25-0.65
Typical value	0.05	1.40	0.35	0.007	0.007	0.14	2.3	0.6

Mechanical properties of deposited metal

Testing status	Yieldstrength (MPa)	Tensilestrength (MPa)	Elongation(%)	-20°C Impact value(J)	-50°C Impact value(J)
Standard value	≥610	≥690	≥16	-	≥27
As-Welded condition	655	725	21	100	73

Shielding gases, polarity and welding position

Gas composition	Power polarity	Welding position
Ar+25%CO ₂		