



WASHINGTON ALLOY'S Quality
Management System is
Certified to ISO 9001:2008
Cert # 05-R0925

101T-GM CORED Welding Wire

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com



ALLOY DESCRIPTION AND APPLICATION:

101T-GM is a flux cored electrode designed for single and multiple pass welding using 75% Argon /25% CO₂ shielding gas welding having a smooth spray-arc transfer commonly used of carbon and low alloy steels, in all positions, where a minimum tensile strength of 100,000 psi is required in the deposited weld metal. This wire normally used in high strength applications which will produce a chemical composition of about 0.5 % molybdenum and less than 1 % nickel yielding strengths ranging from 80-100 ksi. Steels commonly welded with this grade may include 4130, 8630 and similar grades that are quenched and tempered.

TYPICAL FCAW WELDING PROCEDURES; DCEP with 75% Ar /25% CO₂ (35-50 cfh)

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stickout
0.045"	250-280-320	150-250-300	23-27-30	1/2-1"

Procedures may vary with change in position, base metals, filler metals, equipment and other changes. **(Based on optimum FLAT)**

TYPICAL UNDILUTED WELD METAL (%) AND WELD METAL PROPERTIES;

U.S. ALLOY 101T-GM

			AWS Spec	Typical
Carbon	0.06			
Manganese	1.42	Tensile Strength (psi)	100-120ksi	111,200
Nickel	0.80	Yield Strength (psi)	88,000 min.	98,500
Silicon	0.32	Elongation in 2"	16% min.	19%
Molybdenum	0.35	Charpy V-notch (-20°F)	N/A	65 ft-lbs
Phosphorus	0.011	(-50°F)		46 ft-lbs
Sulfur	0.007			

AVAILABLE SIZES: TCF 101T-G = Spools of .045

Other sizes may be available – please inquire

SPECIFICATIONS; AWS A5.29/ E101T-GM
ASME SFA A5.29 E101T-GM

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