

GENERAL DESCRIPTION

Elite 801 is a low carbon, copper coated GMAW wire with high manganese and silicon content, providing welds with flatter bead shapes and lower splatter. Optimized for welding steels with moderate amounts of mill scale or rust with uniformed layer wound and copper coating to extend the life of consumable MIG parts.

Excellent welding for general steel construction, sheet metal and structural welding of mild and medium strength steels and designed for use with optimum performance under Argon75/25 Ar/CO² and 100% CO² shielding gases.

APPLICATIONS:

- General Fabrication
- Shipbuilding
- Construction
- Mobile Machinery
- Automotive
- Farm equipment

WELDING POSITIONS



CLASSIFICATION

AWS/ASME-SFA A5.18 ER70S-6

AS/NZS 14341B-G 49A 3U C S6

AS/NZS 14341B-G 49A 3U M S6

RECOMMENDED SHIELDING GASES

ISO 14175 : M21

ISO 14175 : C1

CHEMICAL COMPOSITION

Wt% - wire	C	Mn	Si	P	S	Ni	Cr	Mo	V	Cu
	0.06-0.14	1.30-1.60	0.7-1.00	<0.025	<0.025	<0.15	<0.15	<0.15	<0.03	<0.35

TYPICAL MECHANICAL PROPERTIES

Typical as welded	ISO 14175 : M21	ISO 14175 : C1
Yield Strength	468MPa	445MPa
Tensile strength	575MPa	548MPa
Elongation	27.5%	24.5%
Impact Energy CVN	75J/ -40° C	57/ -30° C

DEPOSITION DATA - DCEP (DC+)

SPRAY TRANSFER

Using 90% Ar / 10% CO ₂	0.8mm Ø	0.9mm Ø	1.0mm Ø	1.2mm Ø
Current (A)	175 - 240	195 - 275	235-285	285 - 340
Voltage (V)	20 - 26	23 - 30	23 - 28	27 - 30
Wire Feed Speed (m/min)	10 - 15.3	9.5 - 15.2	9.0 - 13	9 - 12
Deposition Rate (kg/h)	2.4 - 3.6	2.7-3.6	3.3-5.0	4.0 - 6.0
Gas Volume (l/min)	8 - 10	9-11	12-13	14 - 15
Electrode stick out (CTWD)	12 - 19mm	12 - 19mm	16 - 22mm	16 - 22mm

DEPOSITION DATA - DCEP (DC+)	SHORT CIRCUIT TRANSFER			
Using CO ₂	0.8mm Ø	0.9mm Ø	1.0mm Ø	1.2mm Ø
Current (A)	35-130	80-175	90-200	145 - 200
Voltage (V)	17-22	18 - 22	19-23	19 - 23
Wire Feed Speed (m/min)	1.9-7.6	2.5 – 6.4	2.7-5.4	3.2 – 5.1
Deposition Rate (kg/h)	0.4-1.6	0.7 – 1.8	1.3-2.1	1.5 – 2.5
Gas Volume (l/min)	6-9	9 - 10	10-11	12 - 13
Electrode stick out (CTWD)	9-12mm	9 – 12mm	12-19mm	12 – 19mm

Welding parameters are a guide only as they are dependent on the machine used, material thickness and operator experience.

No data is to be construed as a recommendation for any welding condition or technique by Euromarc.

CONFORMANCE AND APPROVAL

ABS – 3Y400

TUV

DB

STORAGE

Store all wire spools in their original packaging in a controlled environment of less than 50% relative humidity.

WARNING

Electric shock can kill. Arc rays can injure eyes. Welding fumes are hazardous to your health and may damage lungs and other organs. Use adequate ventilation. Arc rays and sparks can injure eyes and burn skin. Wear correct hand, head, eye and body protection.

Read and understand the Safety Data Sheet for this product.

PACKAGING INFORMATION

Size	Weight	Spool	Vacuumed Packed	Part Number / Order code
0.8	15kg	D300	YES	VW80100815
0.9	15kg	D300	YES	VW80100915
1.0	15kg	D300	YES	VW80101015
1.2	15kg	D300	YES	VW80101215
0.9	250Kg	Bead Drum	No	VW80109250
1.0	250Kg	Bead Drum	No	VW80110250
1.2	250Kg	Bead Drum	No	VW80112250

