

A large-scale construction site for an offshore oil rig. Several tall, black lattice-structured towers are being erected against a clear blue sky. A red crane is visible in the middle ground, and a red lifeboat is mounted on the lower part of the structure. The rig is mounted on a white platform with yellow railings. The text 'ULTRACORE' is prominently displayed in white on a dark grey background in the lower center of the image.

ULTRACORE

TOUGH FLUX-CORED WIRE FOR DEMANDING OFFSHORE WORK

LINCOLN[®]
ELECTRIC

NABORS
RIG 660



Tough Flux-Cored Wire For Demanding Offshore Work

If you're in the business of offshore fabrication – where your work is used in one of the most unforgiving industrial environments – you need a tough welding wire that's up to the task. Our premium UltraCore® gas-shielded flux-cored wire creates a tough weld that stands up to temperature extremes, corrosive saltwater, constant moisture and other adverse conditions, while exceeding demanding industry requirements. Get tougher, higher quality welds in offshore and other environments where these attributes matter most.

Ultra Performance. Ultra Dependability.



Resilience, Simplicity, and Quality

UltraCore wires are offered in four distinct platforms. Individually, each platform provides unique advantages; together, they make up a complete portfolio of products to address every application requirement. Whether you are looking for a flux-cored wire with robust mechanicals, higher deposition rates, a fluid slag for easy puddle manipulation, or industry-leading documentation, we have an UltraCore wire to meet your needs. If you're planning to weld decking, piping, or TKY joints, there is an UltraCore wire for your application.

Four Distinct Platforms:

Classic Series – Enhanced Puddle Control

This group of wires is an excellent choice for low to moderate wire feed speeds and voltage ranges. These wires produce great wet-in characteristics. Choose Classic Series wires for greater flexibility to manipulate the puddle.

HD Series (High Deposition) – Maximum Weld Position Flexibility

A faster freezing slag and an optimized formulation produce higher deposition rates and a flat bead shape, even out-of-position. These fast freezing characteristics allow a welder to set procedures once and get high deposition rates regardless of welding position. The HD Series produces premium arc performance at moderate to high wire feed speed and voltage ranges.



SR and Plus Series

When mechanical properties take on even greater significance

SR Series (Stress-Relieved) – Optimized for Heat Treatment

Choose this wire series to maintain key mechanical properties before and after post-weld heat treatment. Like Classic Series wires with a similar slag system, SR Series wires perform best at low to moderate wire feed speed and voltage ranges.

Plus Series – Tough at Low Temperatures

This series delivers unparalleled arc performance with comprehensive best-in-class properties, in both the as-welded and stress-relieved conditions. Plus Series wires maintain impact toughness at temperatures as low as -60°F (-51°C), and all are designated H4, meaning each offers a low diffusible hydrogen level of 4ml per 100g of deposited weld metal. This series performs best at moderate to high wire feed speed and voltage ranges.

Lincoln Electric's Q2 lot testing is standard for Plus Series wires. That means every batch of material you buy is lot controlled with actual composition and mechanical properties. These Q2 lot certs are readily available on www.lincolnelectric.com.

ULTRACORE® WIRES

Series	AWS Class	Intended Shielding Gas Mix		
		100% CO ₂	Mixed Gas - (Argon/CO ₂ blend)	Dual Gas - (100% CO ₂ or Argon/CO ₂ blend)
Classic Series	E70T1 (T9)	70C		
	E70T5	75C		
	E71T1 (T9)	71C	71A85	71A75 Dual
	E71T1 (T12)	712C	712A80, 712A80-H	
	E81T1-Ni1	81Ni1C-H	81Ni1A75-H	
	E81T1-Ni2	81Ni2C-H	81Ni2A75-H	
	E81T1-K2	81K2C-H	81K2A75-H	
HD Series	E71T1 (T9)	HD-C, HD Marine	HD-M	
	E71T1 (T12)	HD-12C	HD-12M	
SR Series	E71T1 (T12)	SR-12C	SR-12H, SR-12M	
Plus Series	E71T1 (T12)	712C-H Plus	712A80-H Plus	
	E81T1-Ni1	81Ni1C-H Plus	81Ni1M-H Plus	
	E81T1-K2	81K2C-H Plus	81K2M-H Plus	
	E91T1-K2	91K2C-H Plus	91K2M-H Plus	
	E101T1-K3	101K3C-H Plus	101K3M-H Plus	
	E111T1-K3	111K3C-H Plus	111K3M-H Plus	
	E121T1-K3	121K3C-H Plus	121K3M-H Plus	

Note: Product numbers for ordering and other details can be found at www.lincolnelectric.com

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TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

CUSTOMER ASSISTANCE POLICY

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com for any updated information.