

ER 110 S-G

CATEGORY	GMAW-GTAW Solid wires
TYPE	Solid wire for GMAW welding high tensile fine grain steels.
APPLICATIONS	Crane building, heavy constructions, lifting, offshore platforms, transport etc.
PROPERTIES	Solid welding wire with excellent welding properties under mixed gas M21 (pure Argon for the Tig process) suitable for high strength fine grain steels in combination with excellent impact toughness at sub zero temperatures.

CLASSIFICATION	AWS A 5.28: ER 110 S-1
	EN ISO 16834-A: G 79 5 M Mn4Ni2CrMo

SUITABLE FOR	S690QL, Dillidur 690, Weldox 700, Naxtra 70, S700MC, Alform 700 M, Domex 700 MC, PAS 70, S770QL
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APPROVALS	CE approved
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WELDING POSITIONS:	
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WELD WIRE ANALYSIS						
	C	Mn	Si	Cr	Ni	Mo
	0.07	1.60	0.45	0.30	2.10	0.40

MECHANICAL PROPERTIES							
Heat treatment	R _{p0,2} (N/mm ²)	R _m N/mm ²	A ₅ (%)	Impact energy (J) ISO-V -20°C	Impact energy (J) ISO-V -40°C	Impact energy (J) ISO-V -60°C	Hardness HRc / HV
AW	>790	>890	16-20		>47		

AW: as welded

WELDING PARAMETERS / PACKING						
	welding parameters			packing		
D (mm)	Voltage (V)	Current (A) DC+	kg spool / drum	kg / spool	kg / pallet	
0.8	15-23	60-180	D-200 - K-300 - POP	5 - 15 - 250	1000 - 1080 - 1000	
1.0	18-28	80-280	D-200 - K-300 - POP	5 - 15 - 250	1000 - 1080 - 1000	
1.2	20-33	120-350	D-200 - K-300 - POP	5 - 15 - 250	1000 - 1080 - 1000	

REDRYING TEMPERATURE	not required
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GAS ACCORDING EN 14175:	M21
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