


CATEGORY	GMAW Solid wires
TYPE	Solid welding wire with high yield strength for fine grain steels.
APPLICATIONS	Crane building, jack ups, lifting, rigs, piping, platforms etc.
PROPERTIES	Extreme crack resistant alloy with high mechanical properties and excellent welding characteristics. High impact strength at sub zero temperatures down to -60 °C. Weldable with Co2 and Mixed gas.

CLASSIFICATION	AWS	A 5.28: ER 110S-G
	EN ISO	16834-A: G 69 6 M21 Mn4Ni1,5CrMo
	F-nr	6
	FM	2

SUITABLE FOR	Naxtra 70, Weldox 700, S690, S620, ESStE 690, 690V, XABO 620, S620QL1, S690QL1, S600MC, S700MC, Naxtra 63, Naxtra 70, Optim 700 mc plus, TStE620, TStE690, Weldox 500, Hardox, L480 - L550, X65, X80, X100, Hardox 400, XAR 400, Dilidur 400, Domex 500 MC, Domex 600 MC, Domex 650 MC, 20MnCr65, 28CrMn43, ASTM: A 517, A 537, A 625, HY100, (16NiCrMo12-6), Oceanfit 100, Oceanfit 690
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APPROVALS	TÜV CE Lloyds DNV
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WELDING POSITIONS:	
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TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)									
C	Si	Mn	P	S	Cr	Ni	Mo	Ti	
0.09	0.6	1.65	0.01	0.01	0.25	1.4	0.45	0.07	

ALL WELD MECHANICAL PROPERTIES						
Heat Treatment	R <sub>p0.2</sub>	R <sub>m</sub>	A <sub>5</sub>	Impact Energy (J) ISO-V		
	MPa	MPa	(%)	-40°C		-60°C
As Welded /	710	790	18	70		55

WELDING PARAMETERS / PACKING					
WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING	PACKING
D (MM)	VOLTAGE (V)	CURRENT (A)	SPOOL TYPE	KG / SPOOL	KG / PALLET
0.8	14-24	60-210	D-200 / K-300 / DRUM	5 / 15 / 250	1000 / 1024 / 1000
1.0	14-30	80-280	D-200 / K-300 / DRUM	5 / 15 / 250	1000 / 1024 / 1000
1.2	23-33	120-350	D-200 / K-300 / DRUM	5 / 15 / 250	1000 / 1024 / 1000

REDRYING TEMPERATURE	Not required
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GAS ACCORDING EN 14175	M21
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