

CATEGORY	GTAW Solid wires	
TYPE	Solid filler metal for GTAW welding high tensile fine grain steels.	
APPLICATIONS	Crane building, heavy constructions, lifting, offshore platforms, transport etc.	
PROPERTIES	Solid filler metal with excellent flowing properties under pure Argon suitable for high strength fine grain steels in combination with excellent impact toughness at sub zero temperatures.	
CLASSIFICATION	AWS	A 5.28: ER 110S-1
	EN ISO	16834-A: W 79 4 I1 Mn3Ni1,5Mo
	F-nr	6
	FM	2
SUITABLE FOR	S690QL, Dillidur 690, Weldox 700, Naxtra 70, S700MC, Alform 700 M, Domex 700 MC, PAS 70, S770QL	
APPROVALS	CE	

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.08	0.5	1.6	0.01	0.01	0.3	1.4	0.3

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V -50°C
As Welded /	810	920	18	65

WELDING PARAMETERS / PACKING

D (MM)	WELDING PARAMETERS		PACKING	
	CURRENT DC-		SINGLE	MASTER
1.6	50-90		5 KG	25 KG
2.4	110-180		5 KG	25 KG
3.2	150-250		5 KG	25 KG

REDRYING TEMPERATURE	Not required
GAS ACCORDING EN 14175	I1