

CLASSIFICATION

EN ISO 16834 : G Mn3Ni1CrMo
AWS A5.28: ER110S-G

(*) Nearest classification

GENERAL DESCRIPTION

It is a low alloyed GMA welding wire, used for the welding fine-grained and high strength steels with a yield strength up to 690 N/mm². It gives a weld metal that is used in operating temperatures down to -40°C with a high toughness value. Especially used for low temperature applications that are manufactured from Ni-Cr-Mo steels.

Industry: Ship building, petro-chemical, construction, crane and bridge fabrication industry.

CHEMICAL COMPOSITION (W%) TYPICAL, WIRE

C	Si	Mn	Ni	Cr	Mo	V	Cu
0.09	0.60	1.65	1.50	0.30	0.30	0.10	< 0.25

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Yield Strength	: 770 N/mm ²
Tensile Strength	: 880 N/mm ²
Elongation (L=5d)	: 21 %
Impact (ISO-V)	: 180 J (+20°C) 70 J (-50°C)

SHIELDING GASES (ISO 14175 / EN 439)

MAG : M21 - Ar + 5-25% Co₂
C1 - Co₂ (100%)

Current Type and Polarity : DC (+)

MATERIALS TO BE WELDED

	DIN	EN
Fine Grained Steels	StE 420 - StE 500 TSStE 420 WStE 420 - WStE 500 TSStE 690 V - StE 690.7 TM	S420N ; S500N S420NL P420NH - P500NH S690QL S690Q L690M
Heat Treated Fine Grained Structural Steels	N-A-XTRA 56, N-A-XTRA 63, N-A-XTRA 70 T1, T1A, T1B HSB 77V, Weldom 700, BH70V HY 90, HY 100, Welten 80, Bisalloy 80	S550QL1, S620QL1, S690QL1 - - -
Pipe Materials	X65, X70, X80 (API 5LX) -	- L485MB, L555MB

PACKING AND DIAMETER INFORMATIONS

Diameter	0.8	1.0	1.2	1.6	2.0	2.4	3.2	Spool Weight
MIG/MAG Wire	-	X	X	-	-	-	-	15 kg

Liability : All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance.

Fumes : Consult information on Welding Safety Sheet, available upon request.

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