Standards

TS EN ISO 16834-A	: G 69 5 M21 Mn3Ni1CrMo
EN ISO 16834-A	: G 69 5 M21 Mn3Ni1CrMo
AWS A5.28	: ER110S-G

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Mo	Ni	Cr	Cu
0.12	0.50	1.7	0.3	1.40	0.3	0.35

Mechanical Properties

Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/-50°C)	Elongation ($(L_o=5d_o)$ (%))
min. 690	770-940	min. 47 J	min.17

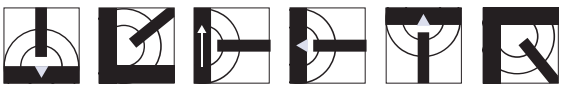
Typical Base Material Grades

- High strength structural steels and fine grained steels
- S690Q, L690M, N-A-XTRA 70, USS-T1, BH 70 V, HY 100, ASTM A514 Gr.F

Features and Applications

- ER 110 SG is low alloyed and high strength GMAW wire and GTAW rods
- It is used for joining of the high strength low alloy steels and the fine grained constructional steels with minimum yield strength of 690 N/mm^2, especially Hardox and Weldox sheets
- Boilers, pressure vessels, pipelines, structure steels are the other application areas
- Weld metal has high impact and toughness at low temperatures
- Pre-heat can be according to the base material
- Shielding gases - MAG: (Ar+% 15-25 CO_2) / TIG: (Ar)

Welding Positions



Current Type

MAG D.C.(+)

Operating Data

Product Code	Diameter (mm)	Diameter (inch)	Weight (Kg)	Package Type
3031100222	1.00	0.040”	15	BS 300 Spool
3031100225	1.20	0.047”	15	