

TIG welding rod and wire

Features:	▪ Suitable for 780MPa tensile strength steel
Classification:	AWS A5.28 ER110S-G
Shielding gas:	Ar
Identification color:-	
Polarity:	DCEN

Packaging data

φ mm	Spool	Tube		
	kg	kg	Length mm	g/piece
1.2	10	5	1,000	9
1.6	-	5	1,000	16
2.0	-	5	1,000	25
2.4	-	5	1,000	35
Volume mm	240W, 110H, 230L	40W, 35H, 1015L		

Composition (wire mass%)

	Typical	Guaranty ^a
C	0.07	0.12
Si	0.07	0.20
Mn	1.10	0.90~1.40
P	0.004	0.025
S	0.008	0.025
Ni	2.92	2.60~3.10
Cr	0.36	0.10~0.60
Mo	0.69	0.40~0.90
Cu	0.14	0.50

Note: ^aSingle values are maximum.

Welding parameters (A)

φ mm	Wire	Rod
1.2	50~280	-
1.6	-	60~220
2.0	-	80~240
2.4	-	100~260

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	760	665min.
TS (MPa)	880	759min.
EI on 4d (%)	23	15min.
IV -60°C (J)	240	27min.

Approvals

LR	5Y69m (H5)
DNV	VY69M, H5