

## ER 110 S-1

**CATEGORY** GMAW-GTAW Solid wires

**TYPE** Solid wire for GMAW welding high tensile fine grain steels.

**APPLICATIONS** Crane building, heavy constructions, lifting, offshore platforms, transport etc.

**PROPERTIES** Solid welding wire with excellent welding properties under mixed gas M21 (pure Argon for the Tig process) suitable for high strength fine grain steels in combination with excellent impact toughness at sub zero temperatures.

**CLASSIFICATION** AWS A 5.28: ER 110 S-1  
EN ISO 16834-A: G 79 5 M Mn3Ni2CrMo

**SUITABLE FOR** S690QL, Dillidur 690, Weldox 700, Naxtra 70, S700MC, Alform 700 M, Domex 700 MC, PAS 70, S770QL

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD WIRE ANALYSIS**

C	Mn	Si	Cr	Ni	Mo
0.07	1.60	0.45	0.30	2.10	0.40

**MECHANICAL PROPERTIES**

Heat treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> N/mm <sup>2</sup>	A <sub>5</sub> (%)	Impact energy (J) ISO-V -20°C	Impact energy (J) ISO-V -40°C	Impact energy (J) ISO-V -50°C	Hardness HRc / HV
AW	>690	>800	21		>47	>80	

AW: as welded

**WELDING PARAMETERS / PACKING**

welding parameters			packing		
D (mm)	Voltage (V)	Current (A) DC+	kg spool / drum	kg / spool	kg / pallet
0.8	15-23	60-180	D-200 - K-300 - POP	5 - 15 - 250	1000 - 1080 - 1000
1.0	18-28	80-280	D-200 - K-300 - POP	5 - 15 - 250	1000 - 1080 - 1000
1.2	20-33	120-350	D-200 - K-300 - POP	5 - 15 - 250	1000 - 1080 - 1000

**REDRYING TEMPERATURE** not required

**GAS ACCORDING EN 14175:** M21