

PRODUCT DATA SHEET

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 Date: 8/26/2015
 Product: ER110S-G
 EN ISO 16834 -A- Mn4Ni2CrMo

NAME OF PRODUCT

ER110S-G

Classifications:

AWS A5.28

ER110S-G

EN ISO 16834 -A- Mn4Ni2CrMo

TYPICAL MECHANICAL PROPERTIES

TENSILE (N/mm ²)	YIELD (N/mm ²)	Al% 5d	CVN + 20°C J	CVN - 50°C J			
980	890	19	120	60			

CHEMICAL COMPOSITION (average)

C %	Si %	Mn %	P %	S %	Cu %	Cr %	Ni %	Mo %	Al %	V %	Zr+Ti			
0.10	0.90	1.80	<0.015	<0.015	<0.25	0.50	2.10	0.55	<0.10		<0.15			

The value of copper (Cu) includes surface coating

WELDING PROCESS

Shielding Gas Mig MAG (80% Argon + 20% CO₂); Argon
 Pre Heating 232°C
 Post Welding as-welded

DIMENSIONS

MIG	0.03	0.035	0.045	1/16										
TIG	1/16	3/32	1/8											

Tolerance according to EN ISO 544

APPLICATION

Suitable for welding of low-alloy steels with very high mechanical properties.
 Especially suitable for welding of fine grain steels with yield limit up to 960 N/mm².

NiCrMo alloyed steel, fine-grained and high yield strength.

Lifting and handling machines, building industry, transport, naval, railway sector, mining industry, petrolchemical industry, etc.