ER110S-G

TOP FEATURES

- Solid TIG rod for welding of Q+T steels requiring as-welded tensile strength up to about 760 MPa
- Not recommended for applications requiring PWHT

CLASSIFICATION

AWS A5.28	ER110S-G
EN ISO 16834-A	W Mn3Ni1CrMo

SHIELDING GASES (ACC. EN ISO 14175)

I1	Inert gas Ar (100%)

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL

	C	Mn	Si	S	P	Cr	Mo	Ni	Cu	V
Typical	0.1	1.6	0.5	0.01	0.01	0.3	0.3	1.4	0.1	0.09

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)		Impact ISO-V (J) -20°C	Hardness cap/mid (HV)
				4d	5d		
Required: AWS A5.28	AW	660	760	15	-	-	-
Typical values	AW	870	940	23	21	120	300

AW = As welded

- = not specified

AVAILABLE SIZES AND PACKAGING INFORMATION

Diameter x Length (mm)	Packaging	Weight (kg)	Item number
2.4	PE Tube	5.0	TER110SG-24

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.