

CLASSIFICATIONS

EN ISO 16834-A : G 69 4 M21 Mn3Ni1 CrMo

AWS A5.28 : ER 110S-G

DESCRIPTION

- WI 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/mm², 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 CO₂) / TIG : (Ar)

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.09 | Si: 0.75 | Mn: 1.70 | Ni: 2.0 | Mo: 0.50 | Cr: 0.30 | Cu: 0.20

MECHANICAL PROPERTIES

Yield Strength (MPa)	Tensile Strength (MPa)	Impact Strength (ISO-V/-30°C)	Elongation (L ₀ =5d ₀) (%)
min. 690	min. 760	min. 47 J	19

BASE MATERIALS

- 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

WELDING POSITIONS



CURRENT CONDITION

MAG D.C.(+) / TIG D.C.(-)

OPERATING DATA

Product Code		Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
BS 300	D 300				
2010100104	2010100108	0.8	0.030"	15	BS/D/300
2010100105	2010100109	1.0	0.040"	15	D 200
2010100106	2010100110	1.2	0.047"	15	D 100
2010100107	2010100111	1.6 (0.6, 0.8, 1.14, 1.4)	0.062"	15 (1.5, 15, 18, 50, 250, 400)	EGO PACK
2010200057		1,60 x 1000	1/16 x 39"	5	Carton Box
2010200058		2,00 x 1000	5/64 x 39"	5	
2010200059		2,40 x 1000	3/32 x 39"	5	