

# ER 110S-G

Low Alloy WIRE/GMAW

## Standards

EN/ISO-Standard - 16834-A

AWS-Standard - A5.28

EN/ISO-Classification - G 69 4 M21 Mn3Ni1CrMo

AWS-Classification - ER 110S-G

## Features and Applications

- A copper coated wire containing NiCrMo for single pass or multipass welding of low alloy steels.
- Designed for welding high yield strength steels with a minimum tensile strength of 770 MPa.
- Excellent impact strength at low temperatures down to -40°C.
- Ideal for steels requiring tough weld metal for critical applications.
- Precision layer wound for superior wire feeding characteristics.
- Typically used in the metal working industry, offshore fabrication, chemical & petrochemical industries etc.
- Green wire is produced using virgin raw materials sourced from specialised steel mills, which ensures consistent reliability and quality.
- **Test Certificates can be found online @wilkinsonstar247.com**



## Typical Base Materials

T1, T1A, T1B, HY90, N-A-XTRA 56-63-65-70, X65, X70, X80, S460, S500, S550, S620, S690, WELDOX 700 etc.\*

\* Illustrative, not exhaustive list

## Welding Positions

EN ISO 6947 - PA, PB, PC, PD, PE, PF, PG

## Shielding Gases

EN ISO 14175 - C1, M20, M21, M33

## Polarity

DC (+)

## Welding Parameters

Ø mm	0.80	1.00	1.20
Current (A)	90-160	150-250	220-320
Voltage (V)	18-22	22-28	26-32

## Mechanical Properties (Typical)

Tensile Strength (N/mm <sup>2</sup> )	Yield Strength (N/mm <sup>2</sup> )	Elongation (%)	Impact Strength (J)	Test Temperature
800	750	19	70	-40°C

Mechanical properties are approximate and may vary based on the heat, shielding gas, welding parameters and other factors.

## Chemical Composition % (Typical)

C %	Si %	Mn %	P %	S %	Cu % <sup>a</sup>	Cr %	Ni %	Mo %	Al %	V %	Ti %	Zr %
0.080	0.60	1.60	<0.015	<0.015	<0.25	0.30	1.50	0.30	<0.030	0.10	<0.050	<0.050

<sup>a</sup> (includes copper coating)

## Packaging Data

Part No.	Diameter Ø (mm)	Package Weight (Kg)	Package Type	Pallet Quantity
3010203706	0.80	15	D300 PLW	72
3010203708	1.00	15	D300 PLW	72
3010203710	1.20	15	D300 PLW	72

**Liability:** Whilst all reasonable efforts have been made to ensure the accuracy of the information contained, this information is subject to change without notice and can be only considered as suitable for general guidance.

