



PRODUCT SPECIFICATION

SPECIAL WELDING MATERIALS

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Date: 2/5/2013
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 MACHANICAL PROPERTIES

Rm (N/mm ²)	Rs (N/mm ²)	Al% 5d	Kv + 20°C J	Kv - 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.