



PRODUCT SPECIFICATION

SPECIAL WELDING MATERIALS

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Date: 8/26/2013
Product: ER110S-1

NAME OF PRODUCT ER110S-1

Classifications: AWS A5.28 ER110S-1

TYPICAL MACHANICAL PROPERTIES

| Rm (N/mm ²) | Rs (N/mm ²) | Al% 5d | Kv + 20°C J | Kv - 50°C J | | | |
|-----------------------------|-----------------------------|--------|----------------|----------------|--|--|--|
| 960 | 870 | 22 | 150 | 90 | | | |

CHEMICAL COMPOSITION (average)

| C % | Si % | Mn % | P % | S % | Cu % | Cr % | Ni % | Mo % | Al % | V % | | | | |
|------|------|------|--------|--------|-------|------|------|------|-------|--------|--|--|--|--|
| 0.08 | 0.45 | 1.70 | <0.010 | <0.010 | <0.25 | 0.15 | 2.10 | 0.40 | <0.10 | <0.030 | | | | |

WELDING PROCESS

| | |
|---------------|------------------------------------|
| Shielding Gas | MAG (Argon + 20% O ₂) |
| Pre Heating | 150°C |
| Post Welding | as-welded |

DIMENSIONS

| MIG | 0.035 | 0.045 | | | | | | | | | | | | |
|-----|-------|-------|-----|--|--|--|--|--|--|--|--|--|--|--|
| TIG | 1/16 | 3/32 | 1/8 | | | | | | | | | | | |

APPLICATION

Fine-grained steels, high yield strength for low temperature application.
Lifting and handling machines, bridges, tanks, transport, shipbuilding, railway sector, mines, vibrant sieves, tank lorries