

GETIG 110SG

IDENTIFICATION

Getig 110SG, ER 110SG

CLASSIFICATION

A5.28/ASME SFA5.28: ER110S-G

DESCRIPTION

Solid wire for gas-shielded metal arc welding of high strength fine grain steel. The wire is alloyed with alloying elements like Nickel, Chromium and molybdenum and deposits high tensile weld metal having UTS of more than 770 MPa.

CHEMICAL ANALYSIS (RANGE) %

C	Si	Mn	Ni	P	S	Mo	Cr	Cu
0.09 max	0.75 max	1.60 max	0.9 min	0.012 max	0.010 max	0.25 max	0.55 max	0.15 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	EL (%)	CVN Impact Value	
			Temp	Joules
760 min	700 min	17 min	-40°C	50

TYPICAL APPLICATIONS

For welding fine grain steel such as HY80, HY100, N-A-XTRA 65-70, T1, T1A, T1B, USS-T1, XABO-90, ST E885 etc.

SPECIAL INSTRUCTIONS

- Use 80% Ar + 20% CO2 gas for shielding
- Flow quantity of shielding gas should be 25 liters/minute, approximately.
- Use wind screen against wind.

SHIELDING GAS : 80% Ar + 20% CO2

WELDING CURRENT : DC (+)

PACKING PARAMETERS

Size (mm)	Length (mm)	Packing / Pkt (kg)	Packing / Box (kg)
1.6	1000	5	5 x 4 = 20
2	1000	5	5 x 4 = 20
2.40 / 2.50	1000	5	5 x 4 = 20
3.15 / 3.20	1000	5	5 x 4 = 20