

GM 110S-G

IDENTIFICATION

GM 110SG, ER 110SG

CLASSIFICATION

AWS 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)	PS (MPa)	EL (%)	CVN Impact Value	
			Temp	Joules
780 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.

WELDING CURRENT : DC (+)

SHIELDING GAS : 80% Ar + 20% CO₂

RECOMMENDED CURRENT (AMPS)

Size (mm)	F & HF
1.2	200~350
1.6	300~550

PACKING PARAMETERS

Size (mm)	Weight / Spool (kg)
1.2	15
1.6	15