GMAW/GTAW LOW ALLOY STEEL (High Strength)

AUTOMIG 110S-G / TIGFIL 110S-G

COPPER COATED MEDIUM ALLOYED WIRE FOR HIGH STRENGTH APPLICATION

CLASSIFICATION : AWS A/SFA 5.28

ER110S-G

KEY FEATURES :

- Copper coated medium alloy steel wire
- Exhibit high strength as well as low temperature toughness
- Excellent welding characteristics
- Exhibit excellent out of position characteristics
- Radiographic quality

WELDING POSITION :

GMAW: DCEP
GTAW: DCEN

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
GMAW: 80Ar+20CO_2	15-25	15-25
GTAW: Ar	10-15	-

TYPICAL APPLICATIONS :

- Welding of high strength low alloy steels
- Welding of HY 80 and other similar grade materials
- Joining large vehicles and crane manufacturing
- Pipelines, tankers, containers

STORAGE / HANDLING :

Keep dry during storage and handling

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :

	C	Mn	Si	Cr	Ni	Mo	Cu	S	P
Typical	0.09	1.6	0.6	0.3	1.4	0.3	0.1	0.015	0.015

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -40°C, J
Typical	As Welded	830	735	23	70

Mechanical properties of weld metal will vary with the type of shielding gas used

PACKING DATA :

	Ø, mm		Kg/Spool	
Automig 110S-G	1.2		15	
	1.6		15	
Tigfil 110S-G	Ø x L, mm	Primary Box, Kg	No. of Primary Boxes	Net Wt. of Carton, Kg
	1.6 x 1000	5	4	20
	2.0 x 1000	5	4	20
	2.5 x 1000	5	4	20