

## Classifications

EN ISO 16834-A	AWS A5.28
G69 4 M Mn3Ni1CrMo	ER110 S-G

## Characteristics and typical fields of application

Solid wire for single or multipass welding of high strength steels with Ar-CO<sub>2</sub> shielding gas such as T1, T1A, T1B, HY80, HY90, NAXTRA 55-60-65-70 and WELDOX 700. We suggest to weld with low heat input to achieve the best mechanical properties.

## Base materials

EN 10028-6: P690QH - P500Q - P690Q - P500QL1 - P690QL1  
 EN 10025-6: S550Q - S620Q - S690Q - S650QL - S620QL - S690QL  
 EN 10208-2: L555QB - L555MB - (X80)

## Typical analysis of all-weld metal (wt.-%)

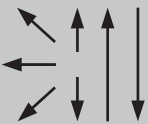
C	Mn	Si	P	S	Mo	Cr	Ni	V	Cu	GAS
0.08	1.55	0.60	< 0.025	< 0.025	0.25	0.35	1.50	0.09	0.25	M21

## Mechanical properties of all-weld metal – typical values (minimum values)

Condition	Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work in J CVN	
	MPa	MPa	%	-	-40°C
u	690	770 - 940	>17	-	65

u: untreated, as welded – shielding gas Ar + 18% CO<sub>2</sub>

## Operating data

	Ø (mm)	Current A	Voltage V
	0.90	35 - 270	15 - 30
	1.00	45 - 270	15 - 32
	1.20	50 - 300	16 - 33
	1.40	60 - 350	20 - 34
	1.60	65 - 390	20 - 35

## Approvals

RINA • TÜV • DB