

## Classifications

<b>AWS A5.28 / SFA-5.28</b>	<b>EN ISO 16834-A -</b>	<b>EN ISO 16834-A</b>
ER110S-G	Mn3Ni2,5CrMo	W 69 6 11 Mn3Ni2.5CrMo

## Characteristics and typical fields of application

GTAW rod for joint welding of high- strength fine- grained constructional steels with stringent requirement on low-temperature toughness down to -60°C. e.g in marine engineering for the manufacture of LPG tankers.

## Base materials

Quenched and tempered fine-grained steels with high requirements for low-temperature toughness S620Q, S620QL, S690Q, S690QL, S620QL1-S690QL1, alform plate 620 M, 700 M, aldur 620 Q, 620 QL, 620 QL1, aldur 700 Q, 700 QL, 700 QL1 ASTM A 514 Gr. F, H, Q ; A 709 Gr. 100 Type B, E, F, H, Q ; A 709 Gr. HPS 100W

## Typical analysis


	C	Si	Mn	Cr	Ni	Mo
wt.-%	0.08	0.6	1.4	0.3	2.5	0.4

## Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength	Tensile strength	Elongation A	Impact energy ISO-V KV J		
	$R_{p0.2}$	$R_m$	( $L_0=5d_0$ )	20°C	-40°C	-60°C
	MPa	MPa	%			
u	750 (≥ 690)	830 (≥ 770 - 960)	22 (≥ 17)	160 (≥ 80)	80 (≥ 47)	(≥ 47)

u untreated, as-welded – shielding gas Argon

## Operating data

	<b>Polarity</b>	DC –	<b>Dimension mm</b>
	<b>Shielding gas (EN ISO 14175)</b>	I1	1.0
	<b>Rod marking</b>	W NiCrMo2.5 ER110S-G	2.0 x 1000
			2.4 x 1000
			2.4 x 1000

Preheating and interpass temperature as required by the base metal.

## Approvals

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