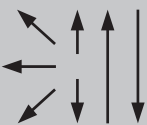


Classifications												
EN ISO 16834-A						AWS A5.28						
G69 4 M Mn3Ni1CrMo						ER110 S-G						
Characteristics and typical fields of application												
Solid wire for single or multipass welding of high strength steels with Ar-CO ₂ shielding gas such as T1, T1A, T1B, HY80, HY90, NAXTRA 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 _{p0.2}		Tensile strength R _m			Elongation A (L ₀ =5d ₀)		Impact work in J CVN				
	MPa		MPa			%		-40°C				
u	690		770 - 940			>17		65				
u: untreated, as welded – shielding gas Ar + 18% CO ₂												
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												