

Low alloy solid wire

Classification

AWS A5.28 :ER110S-G
 EN ISO 16834-A :G 69 4 M Mn3Ni1CrMo

General Description

Solid wire for welding high-strength steels with a yield strength of over 690 N/mm²
 Good impact values at -50 °C

Shielding gas (acc. EN 439)

GMAW M21 Mixed gas Ar+ >5-25% CO₂
 C1 Active gas 100% CO₂

Approvals

GMAW TÜV CE
 + +

Chemical composition (% by mass), typical, all-weld metal

C	Mn	Si	Cr	Mo	Ni	V	Cu
0.089	1.54	0.53	0.26	0.24	1.23	0.08	0.25

Mechanical properties, all-weld metal

	Process	Shielding gas	Condition	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation (%)	Impact (ISO), J -40°C
Typical values after welding	GMAW	M21	AW	690	770	17	47

Materials to be welded

Steel	Code	Type
Pipe material	API-5LX	X65, X70, X80
	EN 10208-2	L480, L550
Fine grained steel	EN 10137-2	S460, S500, S550, S620, S690

Packaging, available sizes and identification

Process	Unit:	Sizes, mm		
		0.8	1.0	1.2
GMAW	15 kg spool B300	X	X	X

Other sizes and packaging on request

Identification

Imprint: Revis®110S-G

Tip colour:

Revis®110S-G: rev.EN 20