



AUTOMIG 110S-G

GMAW LOW ALLOY STEEL (High Strength)

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

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


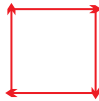
TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Si	Cr	Ni	Mo
0.08	1.6	0.6	0.3	1.4	0.3

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

PARAMETERS - PACKING DATA:

Ø, mm	Kg/Spool		
1.2	15	 DCEP STORAGE / HANDLING : Keep dry and follow handling instructions mentioned on the box	All Positions 
1.6	15		

Shielding Gas	Gas Flow Rate, LPM
Ar/1-5O ₂	15-20