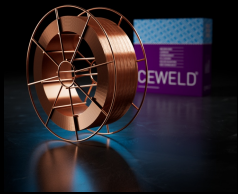


# CEWELD ER 110 S-1

|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                              |                      |                    |                         |      |     |      |      |          |       |
|---------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------|----------------------|--------------------|-------------------------|------|-----|------|------|----------|-------|
| TYPE                                              | Solid wire for GMAW welding high tensile fine grain steels.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                              |                      |                    |                         |      |     |      |      |          |       |
| TOEPASSINGEN                                      | Crane building, heavy constructions, lifting, offshore platforms, transport etc.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                              |                      |                    |                         |      |     |      |      |          |       |
| EIGENSCHAPPEN                                     | Solid welding wire with excellent welding properties under mixed gas M21 (pure Argon for the Tig process) suitable for high strength fine grain steels in combination with excellent impact toughness at sub zero temperatures.                                                                                                                                                                                                                                                                                                                                                                                                                                 |                              |                      |                    |                         |      |     |      |      |          |       |
| CLASSIFICATIE                                     | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | A 5.28: ER 110S-1            |                      |                    |                         |      |     |      |      |          |       |
|                                                   | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | 16834-A: G 69 5 M Mn3Ni1,5Mo |                      |                    |                         |      |     |      |      |          |       |
|                                                   | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | 6                            |                      |                    |                         |      |     |      |      |          |       |
|                                                   | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | 2                            |                      |                    |                         |      |     |      |      |          |       |
| GESCHIKT VOOR                                     | <b>Reh &lt; 690 MPa Iso 15608: 3.2 ( 460 &lt; Reh ≤ 690 MPa)</b><br>1.8914, 1.8927, 1.8931, 1.8928, 1.7147, 1.7149, 1.8734<br>S620Q, S620QL, S690Q, S690QL, S620QL1-S690QL1, 20MnCr65, 28CrMn4-3<br>L480 - L550, X65, X80, X90, X100<br>ASTM A 514 Gr. F, H, Q; A 709 Gr. 100 Type B, E, F, H, Q; A 709 Gr. HPS 100W<br>Weldox 700, Dillimax 690, Hardox, Naxtra 63, Naxtra 70, Optim 700 mc plus, Weldox 500, Hardox, Domex 460 MC, Domex 500 MC, Domex 550 MC, Domex 600 MC, Domex 650 MC, Domex 700 MC, Hardox 400, XAR 400, Dillidur 400, Oceanfit 100, Oceanfit 690, alform plate 620 M, 700 M, aldur 620 Q, 620 QL, 620 QL1, aldur 700 Q, 700 QL, 700 QL1 |                              |                      |                    |                         |      |     |      |      |          |       |
| GOEDKEURINGEN                                     | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                              |                      |                    |                         |      |     |      |      |          |       |
| LASPOSITIES                                       | <div>PAPBPCPDPEPF</div>                                                                                                                       |                              |                      |                    |                         |      |     |      |      |          |       |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | Si                           | Mn                   | P                  | S                       | Cr   | Ni  | Mo   | V    | Cu       | Other |
|                                                   | 0.07                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | 0.65                         | 1.65                 | 0.009              | 0.005                   | 0.24 | 1.9 | 0.35 | 0.01 | 0.005    | 0.15  |
| MECHANISCHE WAARDEN                               | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | R <sub>P0,2</sub> (MPa)      | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |      |     |      |      | Hardness |       |
|                                                   | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | 690                          | 800                  | 18                 | -50°C                   |      |     |      |      | 55       |       |
|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                              |                      |                    |                         |      |     |      |      | HRc      |       |
| HERDROGEN                                         | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                              |                      |                    |                         |      |     |      |      |          |       |
| GAS ACC. EN ISO 14175                             | M21                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                              |                      |                    |                         |      |     |      |      |          |       |



# CEWELD ER 110 S-1

ER 110 S-1 1,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663417206 |

ER 110 S-1 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663417220 |