ER 110S-G

Low Alloy WIRE/GTAW

Standards

EN/ISO-Standard - 16834-A
EN/ISO-Classification - Mn3Ni1CrMo

AWS-Standard - A5.28
AWS-Classification - ER 110S-G

Features and Applications

- A copper coated wire containing NiCrMo for single pass or multipass welding of low alloy steels.
- Designed for welding high yield strength steels with a minimum tensile strength of 770 MPa.
- Excellent impact strength at low temperatures down to -40°C.
- Ideal for steels requiring tough weld metal for critical applications.
- Typically used in the metal working industry, offshore fabrication, chemical & petrochemical industries etc.
- Green wire is produced using virgin raw materials sourced from specialised steel mills, which ensures consistent reliability and quality.
- **Test Certificates can be found online @wilkinsonstar247.com**

GREEN WIRE

Typical Base Materials

T1, T1A, T1B, HY90, N-A-XTRA 56-63-65-70, X65, X70, X80, S460, S500, S550, S620, S690, WELDOX 700 etc.

* Illustrative, not exhaustive list

Welding Positions

EN ISO 6947 - PA, PB, PC, PD, PE, PF

Shielding Gases

EN ISO 14175 - TIG: I1 (Argon)

Polarity

DC (-)

Mechanical Properties (Typical)

Tensile Strength (N/mm²)	Yield Strength (N/mm²)	Elongation (%)	Impact Strength (J)	Test Temperature
800	750	19	70	-40°C

Mechanical properties are approximate and may vary based on the heat, shielding gas, welding parameters and other factors.

Chemical Composition % (Typical)

C %	Si %	Mn %	P %	S %	Cu %ᵃ	Cr %	Ni %	Mo %	Al %	V %	Ti %	Zr %
0.080	0.60	1.60	<0.015	<0.015	<0.25	0.30	1.50	0.30	<0.030	0.10	<0.050	<0.050

ᵃ (includes copper coating)

Packaging Data

Part No.	Diameter Ø (mm)	Package Length (mm)	Package Weight (Kg)	Package Type
3010300470	1.60	1000	5	Cardboard Tube
3010300472	2.40	1000	5	Cardboard Tube
3010300473	3.20	1000	5	Cardboard Tube

Made in Italy

WELD STAR®