

## ER110S-G

### Conformance

AWS A5.28 ER110S-G

### Typical Application

• Suitable for welding 790MPa high strength weathering steel, such as pressure vessels, construction machinery, and hosting machinery

### Mechanical Properties

| Tensile Strength (MPa) | Yield Strength (MPa) | Elongation (%) | Impact Energy (J) | Impact Temperature (°C ) |
|------------------------|----------------------|----------------|-------------------|--------------------------|
| 840                    | 730                  | 24.5           | 85, 93, 75        | -40                      |

### Chemical Composition %

| C     | Mn        | Si        | S      | P      | Ni        | Mo        | Cr        | Cu    | Ti    |
|-------|-----------|-----------|--------|--------|-----------|-----------|-----------|-------|-------|
| ≤0.10 | 1.40~1.85 | 0.40~1.00 | ≤0.025 | ≤0.025 | 1.20~2.40 | 0.20~0.60 | 0.25~0.60 | ≤0.50 | ≤0.16 |

### Reference

| Shielding Gas              | Ar+20%CO <sub>2</sub> |        |        |         |
|----------------------------|-----------------------|--------|--------|---------|
| Gas Flow Rate (L/min)      | 15                    | 15~20  | 15~25  | 20~25   |
| Diameter (mm)              | 0.8                   | 1.0    | 1.2    | 1.6     |
| Current(A) DC <sup>+</sup> | 50~100                | 50~220 | 80~350 | 170~550 |