

**Welding low alloy high strength steels****CLASSIFICATION**

EN ISO 16834-A (G 69 2 M21 Mn3Ni1CrMo)  
A5.28 (ER110S-G)

**GENERAL DESCRIPTION**

Welding wire for joining low alloy steel, fine grain and TMCP steel with a high yield point.  
High impact strength also at temperatures subzero.

**TYPICAL USE**

Welding of steels like T1 steel, T1-A and T1-B, HOAG N-A-XTRA 56, 63, 65, 70,  
Superelso 700, HY80, HY100, Dillimax 690, Weldox 700, etc.  
Parts and chassis of earth moving machines, dredging equipment, mining equipment, etc.  
Welding of high strength rails.  
Repair on forklifts.  
Heavy loaded machinery.

**CHEMICAL COMPOSITION (%) (Typical values, all weld metal)**

C	Mn	Si	Cr	Mo	Ni	V
0.07 - 0.12	1.30- 1.80	0.40 - 0.70	0.20 - 0.40	0.20 - 0.30	1.40 - 1.60	0.05 - 0.13

**MECHANICAL PROPERTIES (Typical values, all weld metal)**

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
> 690 MPa	770-940 MPa	> 17%	> 47 J (-20°C)

**General information**

**Welding positions:** All, except vertical down.

**Shielding gas:** Ar/CO<sub>2</sub>, M21 (EN ISO 14175) or 100% CO<sub>2</sub>

**Dia (x length) (mm):** 0.8 - 1.6

**Packing:** 15 kg spool (in cardboard box)

**Polarity:** NA

**Tips & tricks:** Remove grease and impurities of the base metal.  
When welding outdoors in open air, use windscreens or curtains against wind and draught and increase the gas flow.

The information in this document is based on intensive tests and is accurate to the best of our knowledge. Do note that these values are only typical values for tests in accordance to prescribed standards. The suitability of the product should always be confirmed by qualification tests before use in any application. The information can be changed without previous notice.