certilas® THE FILLER METAL SPECIALIST

CEWELD ER 110 S-1

TYPE	Solid wire for GMAW welding high tensile fine grain steels.
APPLICATIONS	Crane building, heavy constructions, lifting, offshore platforms, transport etc.
PROPERTIES	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.

CLASSIFICATION

AWS	A 5.28: ER 110S-1
F-nr	6
FM	2

SUITABLE FOR

Reh < 690 MPa Iso 15608: 3.2 (460 < Reh ≤ 690 MPa)
1.8914, 1.8927, 1.8931, 1.8928, 1.7147, 1.7149, 1.8734
S620Q, S620QL, S690Q, S690QL, S620QL1-S690QL1, 20MnCr65, 28CrMn4-3
L480 - L550, X65, X80, X90, X100
ASTM A 514 Gr. F, H, Q; A 709 Gr. 100 Type B, E, F, H, Q; A 709 Gr. HPS 100W
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

APPROVALS

CE

WELDING POSITIONS

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

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V -50°C
As Welded /	760	880	18	55

REDRYING TEMPERATURE	Not required
GAS ACCORDING EN 14175	M21

CEWELD ER 110 S-1

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ER 110 S-1 1,0MM

Type	KG/unit	EANCode
BS-300	15	8720663417206

ER 110 S-1 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663417220