

SM-110 (HD)

AWS A5.28/ ASME SFA5.28 ER110S-G

EN ISO 16834-A-G69 4M21 Mn3Ni1CrMo



❖ Specifications

AWS A5.28/ ASME SFA5.28 ER110S-G
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❖ Applications

Gas shielded welding wire conforming to the standard UNI EN ISO 16834-A
-G69 4M21 Mn3Ni1CrMo and AWS A5.28 ER110S-G suitable to join high Strength and
Cr-Ni-Mo low alloy steels.
Available in copper wire and no-copper wire

❖ Chemical composition

C	Mn	Si	P	S	Cr	Ni	Mo	Cu	Al	V	Ti
0.08	1.60	0.50	-	-	0.30	1.40	0.24	-	-	0.08	-
0.11	1.80	0.70	0.015	0.018	0.40	1.60	0.30	0.35	0.12	0.13	0.10

❖ All Weld Metal Mechanical Properties

Tensile Test			CVN Impact Test (Joule)	
YS(MPa)	TS(MPa)	El(%)		
≥ 690	≥ 770	≥ 17	-40 °C	≥ 47

Gas protection : ISO 14175 M21 mixture.

Preheating and interpass temperature : 120 ÷ 180 °C

Recommended welding parameters (diam. 1.2 mm) :

250 ÷ 300A ; 25 ÷ 30V; wire feed speed ~5m/min; travel speed ~6mm/min;
Tip to work ~20mm

❖ Package

SM-110 (HD) (GMAW)	Size (mm)	0.8	1.0	1.2	1.4	1.6
	Weight	Spool : 15 kg / Drum : 250, 350, 450 kg				

❖ Approvals

CE, TUV