



# 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.

**PROPRIÉTÉS** 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

**CONVIENT POUR**

**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

**AGRÉMENTS** CE

**POSITIONS DE SOUDAGE**



**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

**PROPRIÉTÉS MÉCANIQUES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				-50°C		
As Welded	760	880	18	55		HRC

**ETUVAGE** Not required

**GAS ACC. EN ISO 14175** M21



# CEWELD ER 110 S-1

ER 110 S-1 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417206

ER 110 S-1 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417220