



CEWELD ER 110 S-1

TYPE Solid wire for GMAW welding high tensile fine grain steels.

APPLICATIONS CEWELD® ER 110 S-1 is extreme crack resistant with high mechanical properties and excellent welding characteristics. High impact strength at sub zero temperatures down to -60 °C.

PROPERTIES CEWELD® ER 110 S-1 is a solid welding wire with excellent welding properties under mixed gas M21 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
EN ISO	16834-A: G 69 5 M Mn3Ni1,5Mo
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

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
				-50°C	
As Welded	690	800	18	55	HRc

REDRYING 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