



# CEWELD ER 110 Ti

|                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                  |          |        |                         |       |          |      |      |
|------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------|----------|--------|-------------------------|-------|----------|------|------|
| TYPE                                                 | Solid welding wire with high yield strength for fine grain steels.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                  |          |        |                         |       |          |      |      |
| APPLICATIONS                                         | Crane building, jack ups, lifting, rigs, piping, platforms etc.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                  |          |        |                         |       |          |      |      |
| PROPRIÉTÉS                                           | Extreme crack resistant alloy with high mechanical properties and excellent welding characteristics. High impact strength at sub zero temperatures down to -60 °C. Weldable with Co2 and Mixed gas.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                  |          |        |                         |       |          |      |      |
| CLASSIFICATION                                       | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | A 5.28: ER 110S-G                |          |        |                         |       |          |      |      |
|                                                      | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | 16834-A: G 69 6 M21 Mn4Ni1,5CrMo |          |        |                         |       |          |      |      |
|                                                      | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | 6                                |          |        |                         |       |          |      |      |
|                                                      | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | 2                                |          |        |                         |       |          |      |      |
| CONVIENT POUR                                        | <b>Reh &lt; 690 MPa ISO 15608: 3.1 ( 460 &lt; Reh ≤ 690 MPa)</b><br>1.8914, 1.8927, 1.8931, 1.8928, 1.7147, 1.7149, 1.8734<br>S620Q, S620QL, S690Q, S690QL, S620QL1-S690QL1, 20MnCr65, 28CrMn4-3<br>L480 - L550, X65, X80, X90, X100<br>ASTM A 514 Gr. F, H, Q; A 709 Gr. 100 Type B, E, F, H, Q; A 709 Gr. HPS 100W<br>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, DNV                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                  |          |        |                         |       |          |      |      |
| POSITIONS DE SOUDAGE                                 | <div> PA</div> <div> PB</div> <div> PC</div> <div> PD</div> <div> PE</div> <div> PF</div> <div> PG</div> |                                  |          |        |                         |       |          |      |      |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL<br>D'APPORT (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | Si                               | Mn       | P      | S                       | Cr    | Ni       | Mo   | Ti   |
|                                                      | 0.09                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | 0.6                              | 1.65     | 0.01   | 0.01                    | 0.25  | 1.4      | 0.45 | 0.07 |
| PROPRIÉTÉS MÉCANIQUES                                | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | RP0,2 (MPa)                      | Rm (MPa) | A5 (%) | Impact Energy (J) ISO-V |       | Hardness |      |      |
|                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                  |          |        | -40°C                   | -60°C |          |      |      |
|                                                      | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | 710                              | 790      | 18     | 70                      | 55    | HRc      |      |      |
| ETUVAGE                                              | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                  |          |        |                         |       |          |      |      |
| GAS ACC. EN ISO 14175                                | M21                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                  |          |        |                         |       |          |      |      |



# CEWELD ER 110 Ti

ER 110 TI 1,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663417213 |

ER 110 TI 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663417282 |