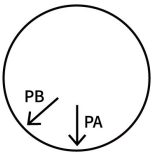


SM-110

Classification

AWS A5.28/ASME SFA-5.28 ER110S-G

Welding Positions



Features

- Excellent TS and impact value at low temperature
- Stable arc with High-Current
- Low spatter

Polarity

DC +

Application Areas

- 0.3Cr-1.9Ni-0.5Mo-alloyed, High strength steel

Shielding Gas

Ar + 20% CO2

Typical Chemical Composition of the Wire (wt%)

C	Si	Mn	P	S	Ni	Cr	Mo
0.09	0.80	1.89	0.009	0.004	1.95	0.34	0.58

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft · lbs)
Ar + 20% CO2	640 (93)	810 (117)	22	-20 (0)	75 (55)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Packaging
1.0 (0.039), 1.2 (0.045), 1.4 (0.052), 1.6 (1/16)	Spool 5kg(11lbs), 15kg(33lbs), 20kg (44lbs) Drum 250kg (551lbs), 300kg (661lbs), 350kg (771lbs)

SMW

GMW

GTW

FCW

Metal-cored Wire

SAW Wire

SAW Flux