

MIDALLOY ER110S-1 WELDING WIRE

CLASSIFICATION

- AWS 5.28 Class ER110S-1 / ASME SFA 5.28 Class ER110S-1. Ref UNS K21015

DESCRIPTION

- MIDALLOY ER110S-1 is a low alloy, bare welding wire suited for MIG or TIG welding.
 - A#2 F#6

APPLICATIONS

- MIDALLOY ER110S-1 is used to weld HY80 and other similar steels with over 100 KSI tensile
- Welds exhibit high strength as well as low temperature toughness down to -60°F.

TYPICAL CHEMISTRY

C	Mn	Si	P	S	Ni	Cr	Mo	V	Ti	Zr	Al	Cu
0.08	1.6	0.45	0.005	0.005	2.2	0.2	0.3	0.03	0.01	.001	0.01	.15

TYPICAL AS WELDED MECHANICAL PROPERTIES

TENSILE STRENGTH	114,000 PSI
YIELD STRENGTH	98,000 PSI
ELONGATION IN 2"	16%
CHARPY V NOTCH @ -60°F	60 ft. lbs.

WELDING PARAMETERS (GMAW)

DIA.	SPRAY TRANSFER			SHORT ARC		
	AMPS.	VOLTS	GAS	AMPS.	VOLTS	GAS
.035"	160-200	28 – 32	98 Ar/2 O ₂	100-140	22 - 25	100% CO ₂
.045"	180-220	30 - 34	75 Ar/25 CO ₂	120-150	23 - 26	75 Ar/25 CO ₂

OTHER INFORMATION

- Mechanical properties are greatly influenced by preheat, interpass temperature, and post weld heat treatment.

STANDARD PACKAGING

- MIG 33 lb. Spool
- TIG 10 lb. Tubes / 60 lb. Carton

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