

❖ Product Description

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| I. Copper coated medium alloy steel wire | IV. High strength and increase in toughness at low temperatures |
| II. Excellent and uniform weld beads | V. Radiographic weld quality |
| III. Also suitable in welding when the parameters differ from normal | |

❖ Range of Application

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| I. For welding high strength low alloy steels | IV. In crane manufacturing and similar heavy industries |
| II. Welding HY 80 and similar grade materials | V. Pipelines, tankers, containers |
| III. Good for welding and joining in heavy machineries | |

❖ Classification

- AWS/SFA 5.28 ER110S- G

❖ % Chemical Composition

- As agreed between supplier and purchaser

❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charpy "v" Notch Impact @ - 30°C
As Welded	760	-	-	-

❖ Wire Size & Welding Position

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|---|-------------------------------|
| • Diameter in mm- 1.60, 2.00, 2.40, 3.20, 4.00, 5.00. | • Weld Position- All position |
|---|-------------------------------|

❖ Current & Gas Flow

- DCEP; 15-22lit/min

❖ Packaging

Sizes Available in mm	0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60								
Packing Code	A	B	C	D	E	F	G	H	I
Packing Available	SD 100	SD200	SD270	SD 270	SD300	SD300	100kg Drum Pack	250kg Drum Pack	350kg Drum Pack
Net Weight of Wire	1KG	2KG	12.5KG	15KG	12.5KG	15KG	100KG	250KG	350KG

Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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