Selectarc WELDING

SELECTARC MIG F78

Old reference : MIG 110 S1

Classification

AWS A5.28 : ER110S G

Characteristics

Spooled GMAW (MIG) wire electrode used to weld high-strength, very tough weld metal for critical applications. Originally developed for welding HY100 steels for military applications. Used for general metal constructions, blacksmithing, ship building etc, It is also used for a variety of structural applications where tensile strength requirements exceed 100 ksi (690 MPa), and excellent toughness is required to temperature as low as -60°F (-51°C).

Applications

Fine grain and Cold tough steels: (*) with eventual pre and post weld heat treatment (consult us).

Base Materials

NF A 36 -204	E 500T* , E 620T* , E 690T*.
DIN 17102	StE 590*, StE 690*, TStE 500* , WStE 500*. 17MnCrMo 33, 11 NiMnCrMo55 , 16 NiCrMo 12, 12MnNiMo 55.
Material N°	1.8928* - 1.7279*- 1.6780* - 1.6343* etc
ASTM	A517 - A533Gr. A - A537 - A678 - A633 Gr. C bis E N-A XTRA ; N-A XTRA70* (Thyssen.)
Tube Steels	Apl 5 LX ; X70* , X75* , X80*

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	S	P	Cu	Fe
0.070	0.40	1.60	0.060	2.00	0.40	0.008	0.010	0.170	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS Rm (MPa)	YS Re (MPa)	% Elg A_5	Impact (KV) Temp.°C	J
AW	790	695	16	-20	80
				-40	75
				-51	68

Welding Current & Instructions

Welding Mode	Wire Ø (mm)	Welding Mode (A)	Welding Mode (V)	Shielding Gas ISO 14175
MIG = +	1.0	150 - 170	25 - 28	M21 (Ar/CO_2)
	1.2	180 - 250	26 - 28	C1 (100% CO_2)
				12 - 15 l/min

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