



T85 Mag

AWS A 5.28: ER110S-G ISO 16834-A: Mn4Ni1,5CrMo
ISO 16834-A: G 89 4 M21

DESCRIPTION

Copper coated low-alloy wire with NiCrMo suitable for single pass or multipass welding of fine grained NiCrMo alloyed steels and steels with high yield strength. Lifting and handling machines, building industry, transport, naval, railway sector, mining industry, petrochemical industry, etc.

WELDING POSITIONS



CURRENT

DC+

GAS

Ar/ Co2 (M21, M20)

BASE MATERIALS

Construction steel, pressure steel, high strength steels

ASTM 514: F; S690Q

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	<i>A5</i> (%)	<i>KV(j)</i>
940	860	18	60 J (-40° C)

WELD METAL COMPOSITION(%)

C	Si	Mn	P	S	Cu	Cr	Ni	Mo	Al	V	Ti	Zr
0,1	0,75	1,8	<0,01	<0,01	<0,25	0,35	1,9	0,5	<0,01	>0,03	0,01	<0,01

PACKAGING & WELDING PARAMETERS

Dimension(mm)	0,8	1,0	1,2	1,6
Spool size(kg)	16	16	16	16
Wire feeding (m/min)	2,0-10,8	2,7-15	2,7-12,4	3,1-12
Ampere (A)	90-160	150-250	220-320	250-400
Volt (V)	18-22	22-28	26-32	28-36

EQUIVALENT FILLER METALS

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Interpass temperature 120-180°C