

TALARC 110

CLASSIFICATION

AWS SPECIFICATIONS	EN SPECIFICATIONS
AWS A5.28: ER110S-1	(EN ISO 16834-A: G 69 5 Mn3Ni2,5CrMo)

ALLOY TYPE

Copper-coated solid wire for welding high strength steels.

APPLICATIONS

Low-alloy copper-coated solid wire with Ni-Cr-Mo additions designed for welding high yield strength steels and with tensile strength higher than 800 MPa. Chemical composition of wire conforming to AWS specifications. Excellent impact strength at low temperatures. Suitable for the metal working industry, offshore fabrication, chemical and petrochemical industry. It also has applications in fabrications of HSLA (high-strength low-alloy) steels, which may be used for industrial machinery construction, cranes and other highly stressed structural components. To be used under the shield of Ar+CO₂.

TYPICAL CHEMICAL COMPOSITION OF WIRE

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %
0.06	1.60	0.40	0.007	0.007	0.30	2.50	0.40	0.12

TYPICAL MECHANICAL PROPERTIES

GAS		Yield strength	Tensile strength	Elongation on % 5d	Impact energy (Charpy V)				
		Rs	Rm	A 5d	+ 20°C	0°C	-20°C	-40°C	-50°C
		(MPa)	(MPa)	%	(Joule)	(Joule)	(Joule)	(Joule)	(Joule)
MIX	as welded	810	910	18	160	-	140	90	-

WELDING GUIDELINES

Preheat and interpass temperature 150°C. PWHT is not required. To obtain the best mechanical properties results, the use with low heat input is advised (follow the steel producer recommendations).

TECHNICAL INFORMATION

Gas: Mix Ar- CO₂ (EN 14175)
Welding position: all positions



WELDING PARAMETERS

Current	DC + Reverse polarity		
Diameter (mm)	0.9	1.2	
Volts (V)	17 ÷ 30	18 ÷ 34	
Intensity (A)	70 ÷ 240	100 ÷ 360	

Diam.	15kg Spool
0.9mm	INM11009
1.2mm	INM11012