

# TALARC 110 TIG

## CLASSIFICATION

| AWS SPECIFICATIONS   | EN SPECIFICATIONS          |
|----------------------|----------------------------|
| AWS A 5.28: ER110S-1 | EN ISO 16834-A: W Mn4Ni2Mo |

## ALLOY TYPE

Copper-coated TIG rod for high strength steels.

## APPLICATIONS

Copper-coated low alloy tig rod with Ni-Cr-Mo for welding high strength steels with minimum yield strength of 760 MPa and minimum tensile strength of 840 MPa. Chemical composition of rod conforming to AWS specification. Excellent mechanical properties of weld metal and good toughness characteristics at low temperature. It could find application in earth moving equipment, cranes and industrial trucks fabrication.

## TYPICAL CHEMICAL COMPOSITION OF WIRE

| C %  | Mn % | Si % | S %   | P %   | Cr % | Ni % | Mo % | Cu % |
|------|------|------|-------|-------|------|------|------|------|
| 0.07 | 1.70 | 0.50 | 0.007 | 0.007 | 0.10 | 2.10 | 0.45 | 0.15 |

## TYPICAL MECHANICAL PROPERTIES

| GAS   |           | Yield strength | Tensile strength | Elongation on % 5d | Impact energy (Charpy V) |         |         |         |         |
|-------|-----------|----------------|------------------|--------------------|--------------------------|---------|---------|---------|---------|
|       |           | Rs             | Rm               | A 5d               | + 20°C                   | -30°C   | -40°C   | -50°C   | -60°C   |
|       |           | (MPa)          | (MPa)            | %                  | (Joule)                  | (Joule) | (Joule) | (Joule) | (Joule) |
| Argon | as welded | 740            | 805              | 16                 | 170                      | 130     | 120     | 95      | -       |

## WELDING GUIDELINES

Preheat and interpass temperature 150 - 200°C. PWHT is not required. To obtain the best results in terms of mechanical properties, use with low heat input is advised (follow instructions as indicated by steel producer).

## TECHNICAL INFORMATION

Gas: Argon 100% (EN ISO 14175)

Welding positions: all positions



## WELDING PARAMETERS and PACKAGING DATA

|               |                            |     |
|---------------|----------------------------|-----|
| Diameter (mm) | 1.6                        | 2.4 |
| Length (mm)   | 1000                       |     |
| Carton        | 5 Kg                       |     |
| Current       | DC - Straight (-) polarity |     |

| Diam. | 5kg Tube |
|-------|----------|
| 1.6mm | INT11016 |
| 2.4mm | INT11024 |

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