

# WEAR S9510 T1S

SFA-AWS A5.28 ER110S-G  
EN ISO 16834-A- G 69 4 M21 Mn3Ni1CrMo  
EN ISO 16834-A- Mn3Ni1CrMo

## Average Chemical analysis

| C%    | Si%  | Mn%  | P%      | S%      | Cu%    | Cr%  | Ni%  | Mo%  | Al%     | V%   | Ti%     | Zr%     |
|-------|------|------|---------|---------|--------|------|------|------|---------|------|---------|---------|
| 0,080 | 0,60 | 1,60 | < 0,015 | < 0,015 | < 0,25 | 0,30 | 1,50 | 0,30 | < 0,030 | 0,10 | < 0,050 | < 0,050 |

The copper value include the surface coating

## Typical mechanical properties of all-weld metal

| Rm                | Rs                | Al  | Kv    |
|-------------------|-------------------|-----|-------|
| N/mm <sup>2</sup> | N/mm <sup>2</sup> | %5d | -40°C |
| 800               | 750               | 19  | 70 J  |

The mechanical properties are approximate and may range on the basis of the Heat, shielding gas, welding parameters and other factors

## Welding process

|                             |   |
|-----------------------------|---|
| Protection                  | MIG: EN ISO 14175 C1, M20, M21, M33 and similar / TIG: I1 (Argon) |
| Current and polarity        | MIG: DC+ / TIG: DC-   |
| Welding positions           | EN ISO 6947: PA, PB, PC, PD, PE, PF, PG                           |
| Interpass temperature       | 120 - 180 ° C   |
| Post Welding Heat Treatment | as welded   |

## Dimensions

|          |   |
|----------|---|
| MIG (mm) | 0,60 - 0,80 - 0,90 - 1,00 - 1,14 - 1,20 - 1,40 - 1,60 |
| TIG (mm) | 1,00 - 1,20 - 1,60 - 2,00 - 2,40 - 3,00 - 3,20 - 4,00 |