TECHNICAL DATA SHEET

parweld
WELDING THE FUTURE

XP 110 — HIGH STRENGTH

CLASSIFICATIONS

EN ISO 16834-A	AWS A5.28
W Mn3Ni1CrMo	ER110S-G

KEY FEATURES AND APPLICATIONS

- Low-alloyed solid wire designed for welding fine-grained, quenched and tempered high-strength steels.
- Provides a minimum yield strength of 690 MPa.
- Ideal choice for steels requiring high-strength and tough weld metal in critical applications.
- Excellent mechanical properties at subfreezing temperatures down to -40°C.
- Widely used in the construction of high-strength pipelines, earthmoving and mining equipment, trucks, mobile cranes, concrete pumps and lifting equipment.

BASE MATERIALS

T1, T1A, T1B, HY90, N-A-XTRA 56-63-65-70, X65, X70, X80, S460, S500, S550, S620, S690, WELDOX

CHEMICAL COMPOSITION OF WIRE %

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu	V	Ti	Zr	Al
MIN	-	0.40	1.30	-	-	1.20	0.20	0.20	-	0.05	-	-	-
MAX	0.12	0.70	1.80	0.015	0.018	1.60	0.40	0.30	0.35	0.13	0.10	0.10	0.12

Single values are maximum values according to EN ISO 16834

MECHANICAL PROPERTIES OF ALL-WELD METAL - TYPICAL VALUES

Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Impact ISO-V (J)	Test Temperature
750	800	19	70	-40°C

Test data for mechanical properties are not guaranteed since actual as welded conditions depend on numerous variables

OPERATING DATA

Shielding Gases	Polarity
EN ISO 14175 - I1	DC-

PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Length (mm)	Weight (kg)	Packaging
XP15358	1.6	1000	5	PAP 20 Tube
XP15360	2.4	1000	5	PAP 20 Tube
XP15362	3.2	1000	5	PAP 20 Tube

MADE IN EU