ER110S -1 is the ideal choice of filler metal when high strength and superior ductility are required at temperatures as low as -75°F.

Typical Applications

• Welding HY100 steels • Lifting and handling machines • Bridges • Tanks • Transport • Shipbuilding • Railway sector • Mines • Vibrant Sieves • Tank lorries

AWS Specification

AWS A5.28/A5.28M:2005
AWS Classification ER110S-1

Welding Current for MIG process

GMAW - DCEP

Typical Wire Chemistry

C 0.09
Mn 1.40 - 1.80
Si 0.20 - 0.55
P 0.010
S 0.010
Ni 1.90 - 2.60
Cr 0.50
Mo 0.25 - 0.55
V 0.04
Ti 0.10
Zr 0.10
Al 0.10
Cu 0.25
OTHER 0.50

Typical Mechanical Properties

(As Welded)
Yield Strength, ksi 95
Tensile Strength, ksi 110
Elongation%, min 15

Welding Positions

F,V,OH,H

Available Diameters MIG and suggested Operating Range in Amps

.035" 100 - 150
.045" 150 - 200

Available Diameters TIG

1/16", 3/32" & 1/8"