ITALFIL T1S 1,0MM/15KG ER110S-G Mn3Ni1CrMo

Tuote	
Tuotekoodi:	ITT1S1015
Viivakoodi:	9655000000003

Tekniset tiedot	
Paino:	1 kg

Kuparipinnoitettu Ni-CrMo-pinnoitteinen niukkaseosteinen lanka, joka soveltuu niukkaseosteisten terästen yksi- tai monikerroshitsaukseen. Sitä voidaan käyttää myös silloin, kun vaaditaan hyviä sitkeysominaisuuksia alhaisissa lämpötiloissa.

T1S

LOW ALLOYED WELDING WIRES

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/mm²	**N/mm²**	**%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

BASE MATERIALS TO BE WELDED	T1, T1A, T1B, HY90, N-A-XTRA 56-63-65-70, X65, X70, X80, S460, S500, S550, S620, S690, WELDOX 700 etc.
APPLICATIONS	Copper coated low-alloy wire with Ni-CrMo suitable for single pass or multipass welding of low-alloy steels. It can be used also when good toughness characteristics in low temperature are requide.