

Applications

SM-110 is a 0.3Cr-1.9Ni-0.5Mo-alloyed, bare, solid wire for the GMAW of high strength steels with low-temperature impact toughness requirements.

Characteristics on Usage

Characteristic features include excellent start properties, trouble-free feeding at high wire speeds and lengthy feed distances, a very stable arc at high welding currents; extremely low levels of spatter, low fume emission, reduced contact tip wear and improved protection against corrosion of the wire.

Notes on Usage

- ① Use with 100%Ar or Ar+2~20%CO₂ gas.
- ② Flow quantity of shielding gas should be 25ℓ /min. approximately.
- ③ Use the wind-screen against wind.

Shielding Gas

Ar + CO₂ (M21)

Current

Pulse

Typical Chemical Composition of Wire (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.089	0.75	1.83	0.015	0.012	0.3	1.90	0.52

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
700 (103,000)	887 (128,700)	19.4	-40 (-40) -60 (-76)	82 (60) 69 (51)

Approval

I Packing (Including Ball Pac)

Dia. (mm)	1.0	1.2	Spool(kg)	5	12.5	15
(in)	.039	.045	(lbs)	11	28	33

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.2 (.045)
F & HF	170 ~ 270