

MIG (GMAW) wires for mild and low alloyed steel

FLIESS
SINCE 1915

ED-FK 800

Classification DIN EN ISO	Classification AWS
16834-A G 69 6 M21 Mn4Ni1,5CrMo	A5.28 ER110S-G, A5.28 ER100S-1
Approvals	Material No.
TÜV 10268.02, CE, DB 42.045.18	-

Characteristics and application

MIG/GMAW wire for welding high strength low alloy steels. Used for welding high strength steels in many high stress, critical applications; also exhibiting excellent toughness down to -60°C. Typical applications can be found in the mining, shipbuilding, automotive and pressure vessel industries.

Base materials

For high strength fine-grained structural steels up to yield strength 690MPa (100ksi).

S500Q-S690Q, S500QL-S690QL, S500QLN-S690QLN, P500Q-P690Q, P500QL1-P690QL1, P500QL2-P690QL2, S770QL

ASTM: HY80, Q1(N)

Typical analysis in %

C	Si	Mn	Cr	Ni	Mo	Ti
0,09	0,55	1,67	0,25	1,52	0,50	0,07

Typical heat treatment

Welding procedure, including preheat temperature, interpass temperature and PWHT, will be dependent on the base material being welded and any applicable design codes.

Mechanical properties of the pure weld metal

Yield strength in Mpa	Tensile strength in Mpa	Elongation in %	Charpy-V-Value (ISO-V) in J
≥ 690	≥ 770	4d/5d: ≥17	RT ≥ 100 -60°C ≥ 47