

ED-FK800 MIG (GMAW) wires for high strength structural steels (NiCrMo)

FLIESS
SINCE 1915

Classification DIN EN ISO

16834-A G 69 6 M21 Mn4Ni1,5CrMo

Material No.

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Classification AWS

A5.28 ER110S-G, A5.28 ER100S-1

Approvals

TÜV 10268, DB 42.045.18, ABS, BV, LR, RINA, RS, DNV, CE, VG 95132

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 crane construction, 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 A514 Steel Grades

EH62, EH69

Typical analysis in %

C: 0,09

Si: 0,55

Mn: 1,67

Cr: 0,25

Ni: 1,60

Mo: 0,50

Ti: 0,07

Yield strength in Mpa

≥ 720

Tensile strength in Mpa

≥ 790

Elongation in %

4d/5d: ≥17

Charpy-V-Value (ISO-V) in J

RT ≥ 100

-60°C ≥ 47

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.

Other products

MIG/GMAW: ED-FK 850, ED-FK1

TIG/GTAW: WSG FK1