

ENERGOMAG 690



Welding wire MIG/MAG

Classifications	EN ISO 16834-A	AWS A 5.28
	G69 4M21 Mn3Ni1CrMo	ER 110S-G

Description Low alloyed wire, used for welding of fine-grained and high strength steels with a yield strength up to 690 N/mm². Especially dedicated for low temperature applications. Used in specialised field of ship building, petro-chemical, construction, crane and bridge fabrication industry.

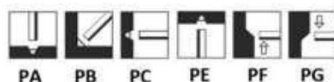
Base materials Fine grained steels: S620Q, S620QL, S690Q, S690QL, N-A-XTRA M 700, alform® 620 M sheet, alform® 700 M, alform® 700 M sheet, aldur 620 Q, 620 QL, aldur 700 Q, 700 QL, Weldom 700

Pipe materials: L485MB; L555MB; X60; X65; X70; X80 (API5LX)

Typical composition of wire (%)	C	Si	Mn	Ni	Cr	Mo	Cu
	0,09	0,75	1,6	0,6	0,55	0,25	<0,25

Mechanical properties of all-weld metal (acc to EN 15792-1, shielding gas M21)	Yield strength 0,2% N/mm ²	Tensile strength N/mm ²	Elongation (L ₀ = 5d ₀) %	Impact value in J CVN -20 °C
	770	880	21	70

Welding positions



Polarity = +

Shielding gases: (EN ISO 14175: M21; C1)

Dimensions (mm)/ 1,0 – 1,6
Packing 15kg spool/ 250kg drum

Certificates CE; TUV

