

MIGWELD 790

MIG/MAG Wires [GMAW]

Construction, unalloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 16834-A : G 69 6 M21 Mn4Ni1,5CrMo AWS A-5.28 : ER 110S-G		Constructions & Engineering Steel construction yards Metallurgy (Steelworks) Shipbuilding&Offshore Automobile

- Welding wire with the addition of Ni, Cr and Mo.
- For finegrained high tensile strenght steels with a yield point up to 690 N/mm2 and impact resistant at very low temperatures (-60°C), such as: steel S690QL, S770QL.

Base material

EN

S500QL - S690QL

S500QLN - S690QLN

S770QL

ASTM A514

EH62, EH69

Typical chemical composition %

C	Si	Mn	Cr	Ni	Mo
0,09	0,55	1,67	0,25	1,60	0,50

Typical mechanical properties

Yield strength Re [N/mm2] >690

Tensile strength Rm [N/mm2] 770-940

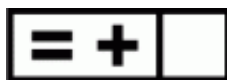
Elongation A5 [%] 17

Impact energy Kv [J] > 47 (-60°C) /

Wire/rod type solid

Heat treatment Depends on base material

Welding current



Welding positions



Shielding gases acc. to EN ISO 14175 M21 - Ar + 15 - 25% CO2 /

Welding parameters and packing

Ø	Welding current [A]	Voltage [V]	Gas flow	Weight of packet [kg]	Weight of carton [kg]
1,2	140 - 280	19 - 28	15 - 25	15	15

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