

ER 100 S-G

CATEGORY	GMAW-GTAW Solid wires	
TYPE	Solid welding wire for high yield strength for fine grain steels.	
APPLICATIONS	Crane building, jack ups, lifting, rigs, piping, platforms etc.	
PROPERTIES	Extreme crack resistant alloy with high mechanical properties and excellent welding characteristics. High impact strength at sub zero temperatures down to -60 degrees Celsius. Weldable with Co2 and Mixed gas.	
CLASSIFICATION	AWS	A 5.28: ER 100S-1 A 5.28: ER 110S-G
	EN ISO	16834-A: G 69 4 M Mn3Ni1CrMo
	DIN	8575:
SUITABLE FOR	Naxtra 70, Weldox 700, S690, S620, ESstE 690, 690V, XABO 620, S620Q11, S690QL1, S600MC, S700MC, Naxtra 63, Naxtra 70, Optim 700 mc plus, TStE620, TStE690, Weldox 500, Hardox, L480 - L550, X65, X80, X100, Hardox 400, XAR 400, Dilidur 400, Domex 500 MC, Domex 600 MC, Domex 650 MC, 20MnCr65, 28CrMn43, ASTM: A 517, A 537, A 625, HY100, (16NiCrMo12-6), Oceanfit 100, Oceanfit 690	
APPROVALS	TUV (12530.01), CE approved	

WELDING POSITIONS:



WELD METAL DEPOSIT

C	Mn	Si	Cr	Ni	Mo	V
0,08	1,60	0,6	0,30	1,50	0,30	0,10

ALL WELD METAL PROPERTIES UNDER M21

Heat treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	>690	>800	>19	>100	>70	>47	

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
0.8	15-24	60-210	D-200 / K-300 / Drum	5 / 15 / 250	1000 / 1080 / 1000
1.0	18-28	80-280	D-200 / K-300 / Drum	5 / 15 / 250	1000 / 1080 / 1000
1.2	20-33	120-350	D-200 / K-300 / Drum	5 / 15 / 250	1000 / 1080 / 1000

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175: M21