

ER 100 S-G Tig

CATEGORY GMAW-GTAW Solid wires

TYPE Solid GTAW welding wire for high yield strength 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.

CLASSIFICATION

| | |
|--------|----------------------------|
| AWS | A 5.28: ER 100S-1 |
| | A 5.28: ER 110S-G |
| EN ISO | 16834-A: W 69 4 Mn3Ni1CrMo |
| DIN | 8575: |

SUITABLE FOR Naxtra 70, Weldox 700, S690, S620, EStE 690, 690V, XABO 620, S620Q11, S690QL1, S600MC, S700MC, Naxtra 63, Naxtra 70, Optim 700 mc plus, TStE620, TStE690, Weldox 500, Weldox 700, 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 CE approved



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 MECHANICAL PROPERTIES

| Heat treatment | R _{p0,2} (N/mm ²) | R _m (N/mm ²) | A ₅ (%) | Impact Energy (J) ISO-V | | | Hardness H _{Rc} / HV |
|----------------|--|-------------------------------------|--------------------|-------------------------|-------|-------|-------------------------------|
| | | | | -20°C | -40°C | -60°C | |
| AW | >690 | >800 | >17 | >100 | >70 | >47 | |

AW: as welded

WELDING PARAMETERS / PACKING

| Welding Parameters | | Packing | |
|--------------------|-------------|--------------|---------------|
| D (mm) | Voltage (V) | Current (A) | spool type |
| 1.6 | 50-90 | 5 kg cartons | 25 kg cartons |
| 2.0 | 70-110 | 5 kg cartons | 25 kg cartons |
| 2.4 | 110-180 | 5 kg cartons | 25 kg cartons |
| 3.2 | 150-250 | 5 kg cartons | 25 kg cartons |

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175: I1