

ER 100 S-G(L)

CATEGORY	GMAW-GTAW Solid wires		
TYPE	Solid welding wire for welding high strenght fine grain steels.		
APPLICATIONS	Crane building, pulling equipment, heavy construction, pipe welding, drilling equipment etc.		
PROPERTIES	Extreme crack resistant alloy with very good deformability properties and excellent welding characteristics. Weldable under Co2 and Mixed gas..		
CLASSIFICATION	AWS	A.5.28: ER 100 S-G	
	EN ISO	16834-A: G 62 4 M Mn3NiCrMo	
	DIN	8575:	
SUITABLE FOR	S620Q11, S600MC, Naxtra63, TstE620, Weldox 500, 600 Hardox, L480 - L550, X65 - X80		
APPROVALS	CE approved		

WELDING POSITIONS:



WELD WIRE ANALYSIS WEIGHT %

C	Mn	Si	Cr	Ni	Mo	Cu	V	P	S
0.08-0.10	1.6-1.8	0.6-0.8	0.55-0.65	0.5-0.6	0.25-0.3	<0.30	<0.03	<0.015	<0.015

MECHANICAL PROPERTIES

Gas type	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	
M21	>620	700	20		>47		

WELDING PARAMETERS PACKING

D (mm)	Welding Parameters		spool type	Packing	
	Voltage (V)	Current (A)		kg / spool	kg / pallet
1,0	15-29	70-280	K-300 / Drum	15 / 250	1080 / 1000
1,2	17-34	100-320	K-300 / Drum	15 / 250	1080 / 1000

REDRYING TEMPERATURE not required

GAS ACCORDING EN 14175: M21