

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 S620QI1, 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

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	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