


CATEGORY	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 °C.

CLASSIFICATION	AWS	A 5.28: ER 100S-G
	AWS	A 5.28: ER 110S-G
	EN ISO	16834-A: W 69 4 11 Mn3Ni1CrMo
	F-nr	6
	FM	2

SUITABLE FOR	Naxtra 70, Weldox 700, S690, S620, ESStE 690, 690V, XABO 620, S620QL1, 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
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APPROVALS	CE
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WELDING POSITIONS:	
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TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)						
C	Si	Mn	Cr	Ni	Mo	V
0.08	0.5	1.6	0.3	1.4	0.3	0.1

ALL WELD MECHANICAL PROPERTIES						
Heat Treatment	R _{p0.2} MPa	R _m MPa	A ₅ (%)	-20°C	Impact Energy (J) ISO-V	
As Welded /	710	800	20	100	-40°C	-60°C
					70	55

WELDING PARAMETERS / PACKING				
D (MM)	WELDING PARAMETERS		PACKING	
	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
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GAS ACCORDING EN 14175	I1
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