

MIG/MAG Welding Wire for High Strength and Low Alloyed Steels

Classification

EN ISO 16834 : G Mn3NiCrMo
AWS A5.28 : ER100S-G

General Description

It is a low alloyed GMA welding wire, used for the welding fine-grained and high strength steels with a yield strength up to 680 N/mm². Especially used for low temperature applications that are manufactured from Ni-Cr-Mo steels.

Industry: Bridge, tank and railway fabrication, mining and ship building industry.

Chemical Composition (w%), Typical, Wire

C	Si	Mn	Ni	Cr	Mo	Cu
0.09	0.75	1.60	0.60	0.55	0.25	< 0.25

Mechanical Properties, Typical, All Weld Metal

Yield Strength	: 680 N/mm ²
Tensile Strength	: 770 N/mm ²
Elongation (L=5d)	: 24 %
Impact (ISO-V)	: 110 J (+20°C) 60 J (-40°C)

Shielding Gases (ISO 14175 / EN 439)

MIG	: M21 - Ar + 5-25% CO ₂ C1 - CO ₂ (100%)
Current Type and Polarity	: DC (+)

Materials to be Welded

	DIN	EN
Fine Grained Steels	StE 460 - StE 620	S620Q ; P460N
Heat Treated Fine Grained Structural Steels	N-A-XTRA 56, N-A-XTRA 63, N-A-XTRA 70 T1, T1A, T1B	S550QL1, S620QL1, S690QL1 -
Pipe Materials	X60, X65, X70, X80 (API 5LX) -	- L485MB, L555MB

Packing and Diameter Informations

Diameter	0.8	1.0	1.2	1.6	2.0	2.4	3.2	Spool Weight
MIG/MAG Wire	X	X	X	-	-	-	-	15 kg