



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

### Classification

TS EN ISO 12534 : G Mn3Ni1,5Mo  
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 AWS A5.28 : ER100S-1

### General Description

NiCrMo alloyed steel with high yield strength above 690 N/mm<sup>2</sup>, suitable for military applications of welding HY-80 and HY-100 steels.

Excellent impact resistance at low temperatures (70J at -50°C).

**Industry:** Shipbuilding sector, structural work, industrial equipment, petrochemical and building industry, cranes, ground movement, tanks, materials handling, military applications.

### Chemical Composition (w%), Typical, Wire

C	Si	Mn	Cr	Ni	Mo	Cu
0.07	0.45	1.60	0.15	1.60	0.30	< 0.25

### Mechanical Properties, Typical, All Weld Metal

Yield Strength : 730 N/mm<sup>2</sup>  
 Tensile Strength : 820 N/mm<sup>2</sup>  
 Elongation (L=5d) : 23 %  
 Impact (ISO-V) : 150 J (+20°C)  
 : 75 J (-50°C)

### Shielding Gases (ISO 14175 / EN 439)

MIG: M21- Ar + 5-25% CO<sub>2</sub>  
 C1 - CO<sub>2</sub> (100%)

Current Type and Polarity : DC (+)

### Materials to be Welded

	DIN	EN
<b>Fine Grained Steels</b>	StE 460 - StE 500 WStE 460 - WStE 500 TStE 690 V - StE 690.7 TM	S460N ; S500N P460NH - P500NH S690QL S690Q L690M
<b>Heat Treated Fine Grained Structural Steels</b>	N-A-XTRA 56, N-A-XTRA 63, N-A-XTRA 70 T1, T1A, T1B HSB 77V, Weldox 700, BH70V, Hardox HY 80, HY 90, HY 100	S550QL1, S620QL1, S690QL1 - - -
<b>Pipe Materials</b>	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	-	-	-	15 kg