

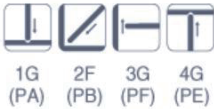
ER100S-G

AWS A5.28 ER100S-G

Description:

ER100S-G is a copper coated low alloy welding wire with a nominal composition (wt-%) of 1.5 Mn, 0.45 Mo, 0.25 Cr, with less than 1% Ni. It is designed for welding steels with tensile strengths higher than 101ksi. It has good impact strength at low temperatures and it is suitable for the metal working industry, offshore fabrication, chemical and petrochemical industries. Typical base material applications are ASTM A 514, A 517, and HY80.

Welding Position:



Diameters:

1,2mm

Typical Mechanical Properties:

Tensile strength(MPa):	660
Yield strength(MPa):	570
Elongation(%):	26
Impact values(≥ 27)/(-20°C):	88

Typical Chemical Compositon:

C	Mn	P	S	Si	Mo	Cr	Ni
0.13	1.50	0.010	0.012	0.60	0.45	0.3	0.95

Welding Current:

Diameter(mm)		1.0	1.2	1.6
Current/A	F/H	80-250	100-360	170-390
Current/A	V/OH	80-160	80-220	--

Note:

1. Rusty, water, oil and other impurity should be cleaned before welding.
2. Shield gas: 100%CO₂ or 80%Ar+20% CO₂.
3. Gas speed: 15-25L/Min
- 4. Tig rods ER100S-G 1.6mm, 2.0mm, 2.4mm, 3.2mm available**