

ER100S-G

LOW ALLOY HIGH TENSILE SOLID WIRES



SIZE	0.9mm	1.0mm	1.2mm	1.6mm
AMPS	75-200A	80-230A	90-350A	170-390A

CHARACTERISTICS

- 1, Good weldability
- 2, Good mechanical properties
- 3, Excellent wire feedability makes it ideal for automatic welding

TYPICAL APPLICATIONS

- 1, NACE applications
- 2, Metal working industry
- 3, Offshore fabrication
- 4, Chemical and petrochemical industries

CLASSIFICATION

AWS A5.28 ER100S-G
EN ISO 16834-A-G 62 4 M21 Z

WELDING POSITIONS (ISO/ASME)



EQUIVALENT TO

CHEMICAL COMPOSITIONS (Wt%), ALL WELD METAL, TYPICAL

C	Si	Cr	Mn	Mo	Ni	P	S
0.13	0.6	0.30	1.5	0.45	0.90	0.01	0.01

AVAILABLE SIZES (DIA.)

0.9mm/1.0mm/1.2mm/1.6mm

PACKAGING DETAILS

15kg Spools ; 250/350kg Drums

CURRENT TYPE

DC+

MECHANICAL PROPERTIES, ALL WELD METAL, TYPICAL

Condition	Shielding Gas	Yield Strength (mpa)	Tensile Strength (mpa)	Elongation(%)	Charpy V notch (J)
AW	80% Ar+20% CO2	660	725	24	-40 C 89

Note:
Shielding gas: 80% Ar+20% CO2

