

Low alloy solid wire

Classification

AWS A5.28-96	: ER100S-G
EN 12534-99	: G 69 4 M Mn3Ni1CrMo

General description

Solid wire for GMA welding at high strength steels with yield strength up to 690 N/mm²
Good impact values at -50°C

Shielding gases (acc. EN 439)

GMAW	M21	Mixed gas Ar+ >5 to 25% CO ₂
	C1	Active gas 100% CO ₂

Approvals

	DB	TÜV
GMAW	+	+

Chemical composition (w%), typical, wire

C	Mn	Si	Ni	Cr	Mo	V	Cu
0.08	1.7	0.44	1.35	0.23	0.3	0.08	0.25

Mechanical properties, typical, all weld metal

	Process	Shielding gas	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J) -40°C
Typical values	GMAW	M21	AW	710	790	20	70

Materials to be welded

Steel	Code	Type
Pipe material	API-5LX	X65, X70, X80
	EN 10208-2	L480, L550
Fine grained steel	EN 10137-2	S460, S500, S550, S620 S690

Packaging

Process	Unit	Sizes (mm)		
		0.8	1.0	1.2
GMAW	15 kg spool B300	X	X	X

Other sizes and packaging on request