

Classifications

EN ISO 16834-A	AWS A5.28
W 55 6 ZMn3Ni0,9MoCr	ER100S-G

Characteristics and typical fields of application

Copper coated, medium-alloy bare wire for quenched and tempered and thermomechanically treated fine-grained structural steels. Excellent weld metal toughness at low temperatures when deposited in combination with gas mixtures. To meet sour gas regulations the Ni-content is kept below 1 %.

Application in crane manufacturing, automobile industry and for components of off-shore equipment like pipework and tubes.

Base materials

S500Q/QL/QL1, S550Q/QL/QL1, P500QL, P550QL

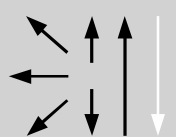
Typical analysis of the TIG rods (wt.-%)

	C	Si	Mn	Cr	Mo	Ni
wt-%	0.08	0.50	1.60	0.27	0.40	0.90

Mechanical properties of all-weld metal

Heat-treatment	Yield strength R _{p0.2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J			
				+20 °C	-20 °C	-60 °C	-70 °C
	MPa	MPa	%				
aw	600	710	18	160	90	55	40
sr (650 °C / 4 h)	520	520	20	200	160	65	40

Operating data

	Polarity:	Shielding gas:	Marks:	∅ mm	L mm	Spool:
	DC (-)	(EN ISO 14175)	↗W ZMn3Ni0,9MoCr	1.0	-	B300
	AC	I1		1.2	-	B300
				2.4	1000	-

Approvals

-