

Standards

TS EN ISO 16834-A	: G 62 4 M21 ZMn 3NiCrMo
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AWS A5.28	: ER 100S-G

**Chemical Composition of
Welding Wire % (Typical)**

C	Mn	Mo	Cr	Ni	Si
0.07	1.55	0.25	0.25	1.50	0.50

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-30°C)	Elongation ((L ₀ =5d ₀) (%))
min. 620	min. 690	min. 47 J	min. 18

Typical Base Material Grades

- S460N, S500N, S550NC, S500NL, N-A-XTRA 56-70, BHV 70, PAS700, HSM700, E 295-E 360

Features and Applications

- ER 100 SG is low alloyed and high strength GMAW wire
- It is used for joining of the high strength low alloy steels and the fine grained constructional steels
- It has high yield strength and impact toughness at low temperatures
- Shielding gases MAG: (Ar+% 15-25 CO₂) / TIG: Ar

Welding Positions

Current Type

TIG D.C.(-) / MAG D.C.(+)

Operating Data

Product Code		Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
BS 300	D 300				BS/D/300
3010203273	3010203296	0.8	0.030"	15	D 200
3010203275	3010203298	1.0	0.040"	15	D 100
3010203277	3010203300	1.2	0.047"	15	ECO PACK
3010203278	3010203302	1.6	0.062"	15	BIG PACK
		(0,6,0,9, 1,14,1,4)		(1,5,15,18,50,250,400)	
	3010300450	1,60 x 1000	1/16 x 39"	5	Carton Box
	3010300451	2,00 x 1000	5/64 x 39"	5	
	3010300452	2,40 x 1000	3/32 x 39"	5	
	3010300453	3,20 x 1000	1/8 x 39"	5	

Approvals: CE, SEPRO