Standards

TS EN ISO 16834-A	: G 62 6 C1/M21 Mn3Ni1Mo
EN ISO 16834-A	: G 62 6 C1/M21 Mn3Ni1Mo
AWS A5.28	: ER 100 S-G

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Ni	Mo
0.09	0.65	1.70	1.15	0.40

Mechanical Properties

Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/-60°C)	Elongation ($(L_o=5d_o)$ (%))
min. 620	700 - 890	min. 47 J	min. 18

Typical Base Material Grades

- P355NL1, P460NL1, StE460-590, USS-T.TTS, TE47-51, N-X-ATRA 70, WTSt37-2, WT37-3, WTSt52- 3
- WT St52-3A, Corten A, Patinax 37, Alcodur 50, Koralpin 52, S255, S550, A516, A350, A612, A255, A299, A333

Features and Applications

- Fine-grained low alloy steels and also austempering steels for applications. Building up of cranes, transport, tanks, industrial facilities, equipment in general, pipelines, shipbuilding, etc
- If necessary, post-weld stress relief shall be heat treated at 560°C-600°C for 1 hour and left in the furnace for cooling down to 300°C
- Shielding gas: $Ar+CO_2$ mix gases can be used

Welding Positions

Current Type

MAG D.C.(+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
6031100218	1.20	0.047”	15	BS 300 Spool

Approvals: CE, SEPRO