



# AUTOMIG 100S-G

GMAW LOW ALLOY STEEL (High Strength)

AWS A/SFA 5.28 **ER100S-G**

## KEY FEATURES:

- Copper coated alloy steel wire
- Ni-Cr-Mo alloyed
- Smooth feedability, low spatter
- Exhibit high strength as well as low temperature toughness
- Radiographic quality

## TYPICAL APPLICATIONS:

- Welding of HY 80 and other similar grade materials
- Welding of high strength and low alloy steels
- Joining large vehicles and crane manufacturing
- Suitable for single and multi-pass welding of low alloy steels

## TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Si	Cr	Ni	Mo
0.07	1.4	0.6	0.45	1.4	0.2

## MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -40°C, J
Typical	As Welded	800	710	24	60

## PARAMETERS - PACKING DATA:

<b>Ø, mm</b> 1.2 1.6	<b>Kg/Spool</b> 15 15	 <b>DCEP</b>	All Positions
<b>STORAGE / HANDLING :</b> Keep dry and follow handling instructions mentioned on the box			

Shielding Gas	Gas Flow Rate, LPM
Ar/1-5O <sub>2</sub>	15-20