



TIGFIL 100S-G

GTAW 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:

Ø x L, mm	Net Wt., Kg		
1.6 x 1000	20	 DCEN STORAGE / HANDLING : Keep dry and follow handling instructions mentioned on the box	All Positions 
2.0 x 1000	20		
2.4 x 1000	20		

Shielding Gas	Gas Flow Rate, LPM
Ar	10-15

Available in Standard carton packing of 20 kg box, containing 4 plastic tubes of 5 kg each.