

MIDALLOY ER100S-1 WELDING WIRE

CLASSIFICATION

- AWS 5.28 Class ER100S-1 / ASME SFA 5.28 Class ER100S-1

DESCRIPTION

- MIDALLOY ER100S-1 is a low alloy, copper-coated welding wire suited for MIG or TIG welding.

APPLICATIONS

- MIDALLOY ER100S-1 is used to weld HY80 and other similar steels.
- Welds exhibit high strength as well as low temperature toughness down to -60°F.

TYPICAL CHEMISTRY

C	Mn	Si	P	S	Ni	Cr	Mo	V	Ti	Zr	Al	Cu
.06	1.4	.45	.005	.005	1.7	.2	.3	.04	.01	.01	.01	.15

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	104,000 PSI
YIELD STRENGTH	92,000 PSI
ELONGATION IN 2"	17%
CHARPY V NOTCH @ -60°F	60 ft. lbs.

WELDING PARAMETERS (GMAW)

DIA.	SPRAY TRANSFER			SHORT ARC		
	AMPS.	VOLTS	GAS	AMPS.	VOLTS	GAS
.035"	160-200	28 - 32	98 Ar/2 O ₂	100-140	22 - 25	100% CO ₂
.045"	180-220	30 - 34	75 Ar/25 CO ₂	120-150	23 - 26	75 Ar/25 CO ₂

OTHER INFORMATION

- Mechanical properties are greatly influenced by preheat, interpass temperature, and post weld heat treatment.

STANDARD PACKAGING

- 33 lb. Spool
- 50 lb. bulk box

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