

MIDALLOY ER100S-G WELDING WIRE

CLASSIFICATION

- AWS 5.28 Class ER100S-G / ASME SFA 5.28 Class ER100S-G EN 12534 G694MGMn3NiCrMo

DESCRIPTION

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

APPLICATIONS

- MIDALLOY ER100S-G is used to weld HY80 and other similar steels.
- Welds exhibit high strength as well as low temperature toughness down to -60°F.
- Used for joining in large vehicle and crane manufacturing.

TYPICAL CHEMISTRY

C	Mn	Si	P	S	Ni	Cr	Mo	V	Ti + Zr	Al	Cu
.08	1.6	.50	.005	.009	1.50	.30	.25	.09	.005	.004	.15

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	120,350 PSI
YIELD STRENGTH	110,200 PSI
ELONGATION IN 2"	19%
CHARPY V NOTCH @ -51°C	70 Joules

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.
- Approvals: TÜV DB

STANDARD PACKAGING

- 33 lb. Spool
- 50 lb. bulk box

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