



CEWELD ER 100 S-G

TYPE	Solid GMAW welding wire for S690 - HY100 type of steels.																	
APPLICATIONS	CEWELD® ER 100 S-G is a copper-coated solid wire for GMAW welding of low-temperature fine-grain steels. The application is: crane construction, heavy machinery, pipelines, platforms, ships, risers etc.																	
PROPERTIES	CEWELD® ER 100 S-G has an extremely crack-resistant weld metal with high mechanical properties and excellent welding characteristics. High notched impact strength at sub-zero temperatures down to -40 °C. Weldable with Co2 and mixed gas.																	
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.28: ER 100S-G</td> </tr> <tr> <td>AWS</td> <td>A 5.28: ER 110S-G</td> </tr> <tr> <td>EN ISO</td> <td>16834-A: G 69 4 M21 Mn3Ni1CrMo</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>2</td> </tr> </table>	AWS	A 5.28: ER 100S-G	AWS	A 5.28: ER 110S-G	EN ISO	16834-A: G 69 4 M21 Mn3Ni1CrMo	F-nr	6	FM	2							
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EN ISO	16834-A: G 69 4 M21 Mn3Ni1CrMo																	
F-nr	6																	
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SUITABLE FOR	<p>Reh < 690 MPa Iso 15608: 2.2 u 3.2 (460 < Reh ≤ 690(700) MPa) 1.7147, 1.7149, 1.8914, 1.8915, 1.8917, 1.8927, 1.8928, 1.8930, 1.8931, 1.8932, 1.8734, 1.8974, S620Q, S620QL, S690Q, S690QL, S620QL1-S690QL1, 20MnCr65, 28CrMn4-3 L480 - L550, X65, X80, X90, X100 ASTM A 514 Gr. F, H, Q; A 709 Gr. 100 Type B, E, F, H, Q; A 709 Gr. HPS 100W Weldox 700, Dillimax 690, Hardox, Naxtra 63, Naxtra 70, Optim 700 mc plus, Weldox 500, Hardox, Domex 460 MC, Domex 500 MC, Domex 550 MC, Domex 600 MC, Domex 650 MC, Domex 700 MC, Hardox 400, Strenx 700; XAR 400, Dillidur 400, Oceanfit 100, Oceanfit 690, alform plate 620 M, 700 M, aldur 620 Q, 620 QL, 620 QL1, aldur 700 Q, 700 QL, 700 QL1, Salzgitter S700MC, Ympress Steel E690 TM, S700MC, Armstrong Ultra 650MC, 650 Mct, 700 MC.....</p>																	
APPROVALS	CE																	
WELDING POSITIONS																		
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td>C</td> <td>Si</td> <td>Mn</td> <td>Cr</td> <td>Ni</td> <td>Mo</td> <td>V</td> </tr> <tr> <td>0.08</td> <td>0.6</td> <td>1.6</td> <td>0.3</td> <td>1.5</td> <td>0.3</td> <td>0.1</td> </tr> </table>	C	Si	Mn	Cr	Ni	Mo	V	0.08	0.6	1.6	0.3	1.5	0.3	0.1			
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ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{P0,2} MPa</th> <th rowspan="2">R_m MPa</th> <th rowspan="2">A₅ (%)</th> <th colspan="3">Impact Energy (J) ISO-V</th> </tr> <tr> <th>-20°C</th> <th>-40°C</th> <th>-60°C</th> </tr> <tr> <td>As Welded /</td> <td>720</td> <td>800</td> <td>19</td> <td>100</td> <td>70</td> <td>50</td> </tr> </table>	Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V			-20°C	-40°C	-60°C	As Welded /	720	800	19	100	70	50
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		-20°C	-40°C	-60°C														
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REDRYING TEMPERATURE	Not required																	
GAS ACCORDING EN 14175	M21, M20																	



CEWELD ER 100 S-G

ER 100 S-G 0,8MM

Type	KG/unit	EANCode
BS-300	15	8720663417121
D-200	5	8720663417114

ER 100 S-G 1,0MM

Type	KG/unit	EANCode
BS-300	15	8720663417138
D-200	5	8720663417152
Drum	250	8720663417145

ER 100 S-G 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663416513
Drum	250	8720663417176

ER 100 S-G 1,6MM

Type	KG/unit	EANCode
BS-300	15	8720663417183