

Low alloy solid wire

Classification

AWS A5.28 : ER100S-G
EN 12534 : G 69 4 M Mn3Ni1CrMo

General description

Solid wire for welding high strength steels with yield strength up to 690 N/mm²
Good impact values at -50°C

Shielding gases (acc. EN 439)

GMAW M21 Mixed gas Ar+ >5 to 25% CO₂
C1 Active gas 100% CO₂

Approvals

TÜV
GMAW +

Chemical composition (w%), typical. wire

C	Mn	Si	Ni	Cr	Mo	V	Cu
0.08	1.7	0.44	1.35	0.23	0.3	0.08	0.25

Mechanical properties, typical, all weld metal

	Process	Shielding gas	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J) -40°C
Typical values	GMAW	M21	AW	710	790	20	70

Materials to be welded

Steel	Code	Type
Pipe material	API-5LX EN 10208-2	X65, X70, X80 L480, L550
Fine grained steel	EN 10137-2	S460, S500, S550, S620 S690

Packaging and available sizes

Process	Unit	Diameter (mm)	0.8	1.0	1.2
GMAW	15 kg spool B300		X	X	X

Other sizes and packaging on request

LNM MoNiVa: rev. EN 20

Liability: All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance **Fumes:** Consult information on Welding Safety Sheet, available upon request