

GETIG 100SG

IDENTIFICATION

Getig 100SG, ER 100SG

CLASSIFICATION

AWS A5.28/ASME SFA5.28: ER100S-G

DESCRIPTION

Solid wire for TIG welding of high strength fine grain steel. The wire is alloyed with alloying elements like Nickel, Chromium and molybdenum and deposits high tensile weld metal having UTS of more than 700 MPa.

CHEMICAL ANALYSIS (RANGE) %

C	Si	Mn	Ni	P	S	Mo	Cr	Cu
0.06 max	0.45 max	1.60 max	1.80 max	0.012 max	0.010 max	0.35 max	0.15 max	0.25 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	EL (%)	CVN Impact Value	
			Temp	Joules
690 min	630 min	22 min	-50°C	65
			-40°C	80

TYPICAL APPLICATIONS

For welding fine grain steel such as

HY80, HY100, N-A-XTRA 65-70, USS-T1, XABO-90, ST E885 etc.

SHIELDING GAS : Pure Argon

WELDING CURRENT : DC (+)

PACKING PARAMETERS

Size (mm)	Length (mm)	Packing / Pkt (kg)	Packing / Box (kg)
1.6	1000	5	5 X 4 = 20
2	1000	5	5 X 4 = 20
2.40 / 2.50	1000	5	5 X 4 = 20
3.15 / 3.20	1000	5	5 X 4 = 20