

ZH-100

For 690MPa tensile strength steel

Classifications

EN ISO 16834-B:2007 : G 69A 2 U M N3M2 JIS Z 3312 : G 69 A 2 M N3M2
 AWS A5.28-05 : ER100S-1

Description

- For butt and fillet welding of machineries, heavy equipments and pressure vessels
- Stable weldability on high welding current
- Beautiful weld appearance due to low spatter with mixture gas

Typical chemical composition of wire (%)

C	Si	Mn	P	S	Ni	Mo
0.05	0.26	1.54	0.008	0.006	2.00	0.35

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -20°C	Remarks
AWS A5.28	min. 610	min. 690	min. 16	≥ 68(@-50°C)	Ar+2% O ₂
EN ISO 16834-B	min. 600	690~890	min. 14	≥ 47	Mix
Example	700	760	20	70	Mix
	720	780	22	130(@-50°C)	Ar+2% O ₂

Operating data

Dia.(mm)		1.2	1.4
Current (Amp.)	Flat (PA/1G)	120 ~ 350	150 ~ 400
	Vertical (PF/3G)	80 ~ 180	100 ~ 250
	Overhead (PE/4G)	80 ~ 180	100 ~ 250

Polarity and Shielding gas

- DCEP (DC+)
- Mix : Ar+20% CO₂ (15~25ℓ /min.)
Ar+2% O₂ (15~25ℓ /min)