

Classifications

AWS A5.28-05	: ER100S-1
EN ISO 16834-B:2007	: W 69A 5 U N3M2
JIS Z 3312	: W 69A 5 U N3M2

Description

- For TIG welding of 690MPa high tensile steel used for pipe line, offshore, structure, construction machinery, pressure vessels, etc
- Used for welding high strength steels in many high stress, critical applications; also exhibiting excellent toughness down to -50°C.
- Typical applications can be found in the mining, mobile cranes, cement pumps shipbuilding, automotive and pressure vessel industries.

Typical chemical composition of rod (%)

C	Si	Mn	P	S	Ni	Mo
0.05	0.26	1.51	0.006	0.005	1.95	0.40

Typical mechanical properties of all-weld-metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -50°C	Remarks
AWS A5.28	min. 610	min. 690	min. 16	≥68	Ar
EN 16834-B	min. 600	690~890	min. 14	≥47	Ar
Example	710	760	27	330	Ar

Operating data

Dia.(mm)	Voltage	Ampere
0.9	10~12	50~70
1.2	10~12	70~100
1.6	12~15	100~125
2.4	15~20	125~175
3.2	15~20	175~200

Polarity and Shielding gas

- DCEN (DC-)
- Ar : 100%Ar (15~25ℓ/min.)