



PRODUCT SPECIFICATION

SPECIAL WELDING MATERIALS

Page: 1 of 1
Date: 8/26/2013
Product: ER100S-1

NAME OF PRODUCT ER100S-1

Classifications: AWS A5.28 ER100S-1

TYPICAL MACHANICAL PROPERTIES

Rm (N/mm ²) 820	Rs (N/mm ²) 730	Al% 5d 23	Kv + 20°C J 150	Kv - 50°C J 75			
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CHEMICAL COMPOSITION (average)

C % 0.07	Si % 0.45	Mn % 1.60	P % <0.010	S % <0.010	Cu % <0.25	Cr % 0.15	Ni % 1.70	Mo % 0.40	V % <0.030	Al % <0.030	Zr % <0.030	Ti % <0.030		
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WELDING PROCESS

Shielding Gas	MAG (Argon + 20% O ₂)
Pre Heating	150°C
Post Welding	as-welded

DIMENSIONS

MIG	0.035	0.045												
TIG	1/16	3/32	1/8											

APPLICATION

NiCrMo alloyed steel with high yield strength for low temperature application.
Shipbuilding sector, structural work, industrial equipment, petrochemical and building industry, cranes, tanks etc.