



# CEWELD ER 100 S-G

## Tig

TYPE	TIG-rod for S690 - HY100 type of steels.																			
APPLICATIONS	CEWELD® ER 100 S-G Tig is a copper-coated solid wire for GTAW welding of low-temperature fine-grain steels. The application is: crane construction, heavy machinery, pipelines, platforms, ships, risers etc.																			
PROPERTIES	CEWELD® ER 100 S-G Tig has an extremely crack-resistant weld metal with high mechanical properties and excellent welding characteristics. High notched impact strength at sub-zero temperatures down to -40 °C.																			
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.28: ER 100S-G, A 5.28: ER 110S-G</td> </tr> <tr> <td>EN ISO</td> <td>16834-A: W 69 4 I1 Mn3Ni1CrMo</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>2</td> </tr> </table>	AWS	A 5.28: ER 100S-G, A 5.28: ER 110S-G	EN ISO	16834-A: W 69 4 I1 Mn3Ni1CrMo	F-nr	6	FM	2											
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F-nr	6																			
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SUITABLE FOR	<p><b>Reh &lt; 690 MPa Iso 15608: 2.2 u 3.2 ( 460 &lt; Reh ≤ 690(700) MPa )</b>            1.7147, 1.7149, 1.8914, 1.8915, 1.8917, 1.8927, 1.8928, 1.8930, 1.8931, 1.8932, 1.8734, 1.8974, S620Q, S620QL, S690Q, S690QL, S620QL1-S690QL1, 20MnCr65, 28CrMn4-3            L480 - L550, X65, X80, X90, X100            ASTM A 514 Gr. F, H, Q; A 709 Gr. 100 Type B, E, F, H, Q; A 709 Gr. HPS 100W            Weldox 700, Dillimax 690, Hardox, Naxtra 63, Naxtra 70, Optim 700 mc plus, Weldox 500, Hardox, Domex 460 MC, Domex 500 MC, Domex 550 MC, Domex 600 MC, Domex 650 MC, Domex 700 MC, Hardox 400, Strenx 700; XAR 400, Dillidur 400, Oceanfit 100, Oceanfit 690, alform plate 620 M, 700 M, aldur 620 Q, 620 QL, 620 QL1, aldur 700 Q, 700 QL, 700 QL1, Salzgitter S700MC, Ympress Steel E690 TM, S700MC, Amstrong Ultra 650MC, 650 Mct, 700 MC...</p>																			
APPROVALS	CE																			
WELDING POSITIONS																				
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>V</th> </tr> </thead> <tbody> <tr> <td>0.08</td> <td>0.5</td> <td>1.6</td> <td>0.3</td> <td>1.4</td> <td>0.3</td> <td>0.1</td> </tr> </tbody> </table>	C	Si	Mn	Cr	Ni	Mo	V	0.08	0.5	1.6	0.3	1.4	0.3	0.1					
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		-20°C	-40°C	-60°C																
As Welded	710	800	20	100	70	55	HRC													
REDRYING	Not required																			
GAS ACC. EN ISO 14175	I1																			



# CEWELD ER 100 S-G Tig

ER 100 S-G TIG 1,6 X  
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663417008

ER 100 S-G TIG 2,0 X  
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663417015

ER 100 S-G TIG 2,4 X  
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663417022

ER 100 S-G TIG 3,2 X  
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663417039