SM-100

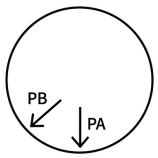
Classification

AWS A5.28/ ASME SFA-5.28 ER100S-G

EN ISO 16834-B-G 69A 4 M21 G

Welding Positions





Features

- Excellent TS and impact value at low temperature
- Stable arc with High-Current
- Low spatter

Polarity

DC +

Application Areas

- 0.3Cr-1.7Ni-0.25Mo-alloyed, High strength steel

Shielding Gas

Ar + 20% CO2

Typical Chemical Composition of the Wire (wt%)

C	Si	Mn	P	S	Ni	Cr	Mo
0.07	0.52	1.71	0.007	0.008	1.78	0.29	0.22

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
Ar + 20% CO2	790 (115)	850 (123)	18	-20 (0) -40 (-40)	70 (52) 40 (30)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Packaging
1.0 (0.039), 1.2 (0.045), 1.4 (0.052), 1.6 (1/16)	Spool 5kg(11lbs), 15kg(33lbs), 20kg (44lbs) Drum 250kg (551lbs), 300kg (661lbs), 350kg (771lbs)