

PRODUCT DATA SHEET

TIG 100



TIG 100 is suitable for the welding of low alloy steels with high yield strength higher than 650 MPa.

Classifications

AWS	A5.28	ER100S-I
EN	16834-A	W 69 5 Mn3Ni1.5Mo
EN	16834-B	W 69 A 4 N3M2 (nearest)

Typical Chemical Analysis

% Carbon	0,07	% Chromium	0,05
% Manganese	1,5	% Nickel	1,6
% Silicon	0,5	% Molybdenum	0,45
% Phosphorous	0,007	% Copper	0,12
% Sulphur	0,007		

Typical Mechanical Properties (All weld metal in the as welded condition)

Tensile Strength	830 MPa
Yield Strength	670 MPa
% Elongation on 5d	19
Charpy V-Notch at -20°C	120 J
Charpy V-Notch at -40°C	80 J
Charpy V-Notch at -60°C	40 J

Packing Data (DC-)

Diameter (mm)	Current		Pack Mass (kg)	Item Number
	Amps (A)	Volts (V)		
2,4	120	14	5,0	W078184

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