



# CEWELD ER 100 S-G

**TYPE** Solid GMAW welding wire for S690 - HY100 type of steels.

**APPLICATIONS** Crane building, jack ups, lifting, rigs, piping, platforms etc.

**PROPERTIES** Extreme crack resistant alloy with high mechanical properties and excellent welding characteristics. High impact strength at sub zero temperatures down to -60 °C. Weldable with Co2 and Mixed gas.

**CLASSIFICATION**

AWS	A 5.28: ER 100S-G
EN ISO	16834-A: G 69 4 M21 Mn3Ni1CrMo
F-nr	6
FM	2

**SUITABLE FOR**

**Reh < 690 MPa Iso 15608: 2.2 u 3.2 ( 460 < Reh ≤ 690(700) MPa )**  
 1.8914, 1.8927, 1.8931, 1.8928, 1.8974, 1.7147, 1.7149, 1.8734  
 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, Armstrong Ultra 650MC, 650 Mct, 700 MC.....

**APPROVALS** TÜV: 12530.01, CE

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

C	Si	Mn	Cr	Ni	Mo	V
0.08	0.6	1.6	0.3	1.5	0.3	0.1

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness
				-20°C	-40°C	-60°C	
As Welded	720	800	19	100	70	55	HRc

**REDRYING** Not required

**GAS ACC. EN ISO 14175** M21



# CEWELD ER 100 S-G

## ER 100 S-G 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417121
D-200	5	8720663417114

## ER 100 S-G 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417138
D-200	5	8720663417152
Drum	250	8720663417145

## ER 100 S-G 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663416513
Drum	250	8720663417176

## ER 100 S-G 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417183