

Classifications

EN ISO 16834-A	AWS A5.28 / SFA-5.28
G 55 5 M Mn3NiCrMo	ER100S-G

Characteristics and typical fields of application

GMAW low-alloyed solid wire for joining of quenched and tempered and thermomechanically rolled fine-grained structural steels with yield strength of 550 MPa. For use in construction, yellow goods, crane and vehicle manufacturing.

Base materials

S420 – S550

Typical analysis


	C	Si	Mn	Cr	Ni	Mo
wt.-%	0.09	0.70	1.50	0.50	0.55	0.25

Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A ($L_0=5d_0$)	Impact energy ISO-V KV J	
	MPa	MPa	%	20°C	-40°C
u	650 (≥ 550)	740 (640 – 820)	20 (≥ 18)	80 (> 47)	65 (> 47)

u untreated, as welded

Operating data

	Polarity	DC+	Dimension mm
	Shielding gas (EN ISO 14175)	M21	1.0
			1.2

Approvals

TÜV (19636), CE