

## ❖ Product Description

- |   |  |
|---|--|
| I. Copper coated solid wire                       | V. High strength and increase in toughness at low temperatures |
| II. Uniform copper coating                        | VI. Radiographic weld quality                                  |
| III. Contains Ni-Cr-Mo                            |  |
| IV. Smooth feedability and low spatter occurrence |  |

## ❖ Range of Application

- |   |   |
|---|---|
| I. For welding HY80 and similar grade material    | III. Extremely good for welding heavy machineries |
| II. Welding of high strength and low alloy steels | IV. For single and multipass welding              |

## ❖ Classification

- AWS/SFA 5.28 ER100S- G

## ❖ % Chemical Composition

- As agreed between supplier and purchaser

## ❖ Mechanical Properties of all weld metal

Condition	UTS, Mpa (Min)	YS, MPa (Min)	% Elongation	Charphy "v" Notch Impact @ -30°C
As Welded	690	-	-	-

## ❖ Wire Size & Welding Position

- Diameter in mm- 0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60
- Weld Position- All position

## ❖ Current & Gas Flow

- DCEP; 15-22lit/min

## ❖ Packaging

Sizes Available in mm	0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60								
Packing Code	A	B	C	D	E	F	G	H	I
Packing Available	SD 100	SD200	SD270	SD 270	SD300	SD300	100kg Drum Pack	250kg Drum Pack	350kg Drum Pack
Net Weight of Wire	1KG	2KG	12.5KG	15KG	12.5KG	15KG	100KG	250KG	350KG

### Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

## SHAKUNT ENTERPRISES PRIVATE LIMITED

**Corporate Office:** - 619/A, EMMAR DIGITAL GREEN, 6th Floor, Sector-61, GURUGRAM (HARYANA)-122102  
E-Mail:- [info@shakunt.com](mailto:info@shakunt.com)

**Ludhiana Works:-** B-XXIX-595/5,Campa Cola Road,Dhandari Kalan Industrial Area-C,Ludhiana (PUNJAB) INDIA

**Dharwad Works:-** Plot no.577 C & D,Belur Industrial Area,Dharwad-580011 (KARNATAKA) INDIA

**Vadodara Works:-** 67-A,G.I.D.C,Majusar,Savli,Vadodara-397115 (GUJARAT) INDIA