

❖ Product Description

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| I. For producing welds with high tensile strength as much as 700Mpa | III. Smooth wire feeding with low spatter occurrence |
| II. Can be used where consumables with less than 1%Ni is required | IV. Radiographic weld quality |

❖ Range of Application:

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|---|---|
| I. For welding pipe lines and pressure vessels operating at high temperatures | III. For welding in crane manufacturing and heavy duty vehicles |
| II. For repairing high strength pipes | |

❖ Classification

- AWS/SFA 5.9 ER100S-G

❖ % Chemical Composition

- As agreed between supplier and purchaser

❖ Mechanical Properties of all weld metal

Condition	UTS, Mpa (Min)	YS, Mpa (Min)	% Elongation	Charpy "v" Notch Impact @-40°C
As Welded	69	-	-	-

❖ Wire Size & Weld Position

- Diameter in mm-1.6, 2.0 2.40,3.20,4.00 and 5.00.
- All position

❖ Current and Gas- Flow Rate

- DCEN & 8-15 lit/min

❖ Packaging

Sizes available in cut length of 1000mm	1.60,2.00,2.40,3.20,4.00,5.00			
Packing Code	A		B	
Packing Available	5kg PLASTIC TUBE	20KG BOX	10KG PAPER TUBE	20KG BOX
Net Weight of Wire	5	20	10	20

Special Note: -

All the value above mentioned are typical values.

- (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.

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