WB100S-G MIG/MAG WELDING WIRE

Classifications	**AWS A5.28:** ER100S-G **ISO BS EN 16834-A:** G 62 4 M21 Mn3NiCrMo
Product Description	Copper coated Chromium-Nickel-Molybdenum solid wire for MIG/MAG welding.
Applications	WB100S-G is a solid wire for the welding of high strength steels. Widely used for the welding of steels with a tensile strength of 700/800 N/mm², such as RQT600, HY80 and NAXTRA 70. The balanced Manganese and Silicon ensures optimum deoxidisation and weld fluidity.

Wire Composition (Wt. %)	C	Mn	Si	S	P	Ni	Cr	Mo	Cu	V
min.	0.06	1.30	0.60	-	-	0.50	0.40	0.15	-	-
max.	0.14	1.80	0.80	0.018	0.015	0.65	0.65	0.20	0.30	0.03

Typical All-Weld Metal Mechanical Properties		
Ultimate Tensile Strength	N/mm²	730 min.
Yield Stress/0.2% Proof Stress	N/mm²	640 min.
Elongation on 5D	%	20 min.
Impact Energy CV @ -40°C As welded	Joules	47 min.

Wire Dia (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	**min.**	-	80	120	160	200	-	-
	max.	-	200	240	300	360	-	-
Volt Range (Volts)	**min.**	-	15	15	15	20	-	-
	max.	-	24	28	30	32	-	-
Packaging Information **Kg Per Reel**		-	15	15	15	15	-	-

Storage	**Storage** It is recommended that the WB range of wires are stored in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60%.
Gases	**Gas** CO_2 and Argon/CO_2 mixture **Flow Rate** 15-20 L/min

Current Conditions DC+ and Welding Positions