



## WB100S-G MIG/MAG WELDING WIRE

<b>Classifications</b>	<b>AWS A5.28:</b> ER100S-G <b>ISO BS EN 16834-A:</b> Mn3NiCrMo									
<b>Product Description</b>	Copper coated Chromium-Nickel-Molybdenum solid wire for MIG/MAG welding.									
<b>Applications</b>	<p>WB100S-G is a solid wire for the welding of high strength steels.</p> <p>Widely used for the welding of steels with a tensile strength of 700/800 N/mm<sup>2</sup>, such as RQT600, HY80, NAXTRA 70, X65, X70, X80., S550, S620, Weldox 500.</p> <p>The balanced Manganese and Silicon ensures optimum deoxidisation and weld fluidity.</p>									
<b>Wire Composition (Wt. %)</b>										
	C	Mn	Si	S	P	Ni	Cr	Mo	Cu	V
<b>min.</b>	0.06	1.30	0.60	-	-	0.50	0.40	0.15	-	-
<b>max.</b>	0.14	1.80	0.80	0.018	0.015	0.65	0.65	0.30	0.30	0.03
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength					N/mm <sup>2</sup>	730			
	Yield Stress/0.2% Proof Stress					N/mm <sup>2</sup>	640			
	Elongation on 5D					%	20			
	Impact Energy CV @ -40°C					Joules	47 min.			
	Impact Energy CV @ -50°C					Joules	50			
	As welded									

<b>Wire Dia (mm)</b>		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>Current Range (Amps)</b>	<b>min.</b>	-	80	120	160	200	-	-
	<b>max.</b>	-	200	240	300	360	-	-
<b>Volt Range (Volts)</b>	<b>min.</b>	-	15	15	15	20	-	-
	<b>max.</b>	-	24	28	30	32	-	-
<b>Packaging Information</b>								
<b>Kg Per Reel</b>		-	15	15	15	15	-	-
<b>Storage</b>	<b>Storage</b> 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%.							
<b>Gases</b>	<b>Gas</b> CO <sub>2</sub> and Argon/CO <sub>2</sub> mixture  <b>Flow Rate</b> 15-20 L/min							

### Current Conditions DC+ and Welding Positions



