



Normalised designations : EN 12534 : G Z Mn 3 Ni 1,5 Mo AWS A5.28 : ER100S-1

Properties :

Full copper wire for welding under gas protection of general-purpose construction steels, weakly alloyed and with high elastic limit. Construction with high mechanical characteristics (Re - 690 MPa).

Applications :

Assembly of HLE steels, anti-wear steels 400 to 500 HB type QUARD (or equivalent), HLE type QUEND (or equivalent- slow) steels, armour plates. Underlayer before hard reloading

Weldable steels : Fine-grained, cold-working steels

NF A 36-204	E 500T - E 620T - E 690T
DIN 17102	StE 590 - StE 690 - TStE 500 - WStE 500 - 17MnCrMo33 - 11NiMnCrMo55 - 16NiCrMo12 - 12MnNiMo55
N° de Matériau	1.8928 - 1.7279 - 1.6780 - 1.6782 - 1.6343 - etc.
ASTM	A517 - A533GrA - A537 - A678 - A633Gr C, D, E
Aciers à tubes	API 5 LX : X70 - X75 - X80

Mechanical characteristics :

Re = 730 MPa Rm = 820 MPa A5 = 19 % KV = 70 J à - 51°C

Settings and conditions: MIG - Continuous Current (electrode)

Gaz (EN 439)	Ø (mm)	Paramètres de soudage	
		Arc pulsé (A)	(V)
M21 (Ar/CO ₂) C1 (100% CO ₂) 12 - 15 L/min	1	150 - 170	25 - 28
	1,2	180 - 250	26 - 28

Packaging : Coil 15 kg

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