



T62

AWS A 5.28: ER100S-G ISO 16834-A: Mn3NiCrMo
ISO 16834-A: G 62 4 M21

DESCRIPTION

Copper coated low-alloy wire with NiCrMo suitable for single pass or multipass welding of low-alloyed high steels with high yield strength. It can be used also when good toughness characteristics in low temperature are required.

WELDING POSITIONS



CURRENT

DC+

GAS

Ar/ Co2 (M21, M20)

BASE MATERIALS

Construction steel, pressure steel, high strength steel

S460, S500, S550, S620, Weldox 600, X60, X65, X70, X80

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	<i>A5</i> (%)	<i>KV(j)</i>
750	650	20	60 J (-40° C)

WELD METAL COMPOSITION(%)

C	Si	Mn	P	S	Cu	Cr	Ni	Mo	Al	V	Ti	Zr
0,09	0,70	1,70	<0,01	<0,01	<0,25	0,50	0,60	0,30	<0,03	0,1	<0,05	<0,05

PACKAGING & WELDING PARAMETERS

Dimension(mm)	0,8	1,0	1,2	1,6
Spool size(kg)	16	16	16	16
Wire feeding (m/min)	2,0-10,8	2,7-15	2,7-12,4	3,1-12
Ampere (A)	90-160	150-250	220-320	250-400
Volt (V)	18-22	22-28	26-32	28-36

EQUIVALENT FILLER METALS

TIG	Meltolit T62
MMA	Meltolit 10018 E

Interpass temperature 120-180°C