

## XCEL-ARC ER100S-G

### HIGH TENSILE MIG WIRE

### Chromium-Nickel-Molybdenum MIG Wire

Classification: AWS : A5.28/ASME SFA5.28 ER100S-G

- High Tensile Welds 690 MPa (100ksi)
- Chrome Nickel Moly Alloyed
- Precision Copper Coating
- X-Ray Quality
- Precision Layer Wound
- Smooth Feeding
- Clean Weld Finish

#### Typical Applications:

Structural steel - Transport industry - Heavy equipment - Earth moving repairs and fabrication, Crane repairs and fabrication. Petrochemical industry

#### Shielding Gas:

75-95% Argon / Balance CO<sub>2</sub>

95-98% Argon / Balance O<sub>2</sub>

#### Application Notes:

XA ER100S-G is a high tensile copper coated, triple de-oxidised solid mig welding wire supplied on 15kg plastic spools. This is a low-alloy mig wire with CR-Ni-Mo additions designed for welding high yield strength steels with minimum tensile strength higher than 770 Mpa. Excellent impact strength at low temperatures down to -50°C. Designed for welding a range of quench and tempered steels and HY-80 base materials and ASTM A514, A543, A724 and A782 quenched and tempered plate. Ideal for Military low alloy applications.

XA ER100S-G wire is Copper Coated for superior arc-starting characteristics and for long contact tip life. Precision Layer Wound for smooth uninterrupted wire feed with less liner and tip wear.

#### Chemical Composition %

≤C 0.076 ≤Si 0.56 ≤Mn 1.47 ≤P 0.011 ≤S 0.003 ≤Cr 0.02 ≤Mo 0.38 ≤Ni 0.83 ≤V -- Fe--

#### Typical Mechanical Properties of Weld metal

Yield Strength	Tensile Strength	Elongation
760MPa	792MPa	25.0%

Part-No	Description	Spool Weight
XA-100SG1015	1.0mm XcelArc ER100S-G High Tensile Mig Wire	15kg
XA-100SG1215	1.2mm XcelArc ER100S-G High Tensile Mig Wire	15kg

