

PRODUCT NAME

SM 100

CONFORMANCES

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

FEATURES

- welded with Ar+20-25% CO2
- Current: DC+
- Good TS and impact value at low temp.
- Stable arc with high current
- Low spatter

APPLICATIONS

- 0.3Cr-1.7Ni-0.25Mo-alloyed, bare, solid wire for the GMAW of high strength steels

CHEMICAL COMPOSITION

	C	Si	Mn	P	S	Cr	Ni	Mo
Ar+20-25% CO2	0.081	0.48	1.76	0.013	0.012	0.28	1.76	0.23

MECHANICAL PROPERTIES

	YS MPa(Lbs/in ²)	TS MPa(Lbs/in ²)	EL (%)	Temp °C(°F)	CVN-impact value J(ft.lbs)
80% Ar + CO2	711(103,100)	756(109,600)	20.4	-20 (4) -40(-40)	114 (84) 83 (61)
90% Ar + CO2	724(105,000)	766(111,100)	18.9	-20 (4) -40(-40)	106 (79) 78 (57)

DIAMETER/PACKAGING

Diameter Mm (in)	Spool	Pac
1.2(0.045)	5Kg 15Kg 20Kg	250Kg 300Kg 350Kg