

Classifications							
EN ISO 16834-A			AWS A5.28				
G 69 6 M21 Mn4Ni1,5CrMo			ER100S-G [ER100S-1(mod.)]				
Characteristics and field of use							
Medium alloy solid wire electrode for shielded arc welding of quenched and tempered and thermomechanically treated fine grained structural steels; for joint welding of wear resistant steels. For use with CO ₂ and gas mixture. Outstanding toughness of the weld metal at low temperatures. For use in crane and vehicle manufacturing.							
Base materials							
S690QL1 (alform 700 M; aldur 700 QL1; Dillimax 690; N-A-XTRA 70; Weldox 700), S620QL1 (Dillimax 620; N-A-XTRA 63), S700MC (alform 700 M; Domex 700 MC; PAS 70)							
Typical analysis in %							
C	Si	Mn	Cr	Mo	Ni		
0.08	0.6	1.7	0.2	0.5	1.5		
Mechanical properties of the weld metal							
Heattreatment	Shielding gas	0.2%-Yield strength	Tensile strength	Elongation (L ₀ =5d ₀)	Impact values CVN		
		MPa	MPa	%	J	-40 °C	-60 °C
U	CO ₂	680	740	18	□80	47	-
U	M21	720	780	16	100	-	47
Approvals							
TÜV (No. 02760), DB (No. 42.132.08), ABS, BV, DNV, GL, LR							
Wire diameter [mm]		Current type		Shielding gas (EN ISO 14175)			
0.8		DC (+)		M21		C1	
1.0		DC (+)		M21		C1	
1.2		DC (+)		M21		C1	
Other spool types on request.							