



Elgomatic 100

GMAW - MIG MAG
Un-alloyed

Date:	2009-04-07
Revision:	11

Description:

Elgomatic 100 is a copper coated, manganese-silicon double deoxidised mild steel wire for use with a CO₂ or Ar/CO₂ gas shield. The carefully controlled wire metallurgy and surface finish ensure high quality welds and reliable wire feed for mechanised welding systems. Elgomatic 100 is suitable for all general engineering and structural steels.

Welding current:

DC+

Wire composition, wt.%

	C	Si	Mn	P	S	Cu
Min	0,07	0,80	1,40			
Typical	0,08	0,85	1,45	0,010	0,015	0,05
Max	0,12	1,00	1,60	0,025	0,025	0,35

Shielding gas:

C1, CO₂, 7-12 l/min

M21, 80% Ar + 20% CO₂, 7-12 l/min

Chemical composition, wt.%

	C	Si	Mn
Min			
Typical	0,07	0,8	1,4
Max			

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Re:	≥ 420 MPa	470 MPa
Tensile Strength, Rm:	≥ 500 MPa	550 MPa
Elongation, A5	≥ 20%	26%
Impact energy, CV:	-20°C • >47 J	-20°C • 85 J
	-29°C • >27 J	-29°C • 50 J

Classification:

EN ISO 14341-A
AWS A5.18

G 42 2 (C) M G3Si1
ER70S-6

Approvals:

TÜV
DB
MRS
DNV
GL
LR
CE

Note

The typical values are based on M21
Also available in AUTOPAC, a twist-free pay-off pack. For more information about Part no, type of spool and winding, please study the price list.

Product data:

Diam.mm	Product code	Spool weight	Dip Current A	Dip Voltage V	Spray Current A	Spray Voltage V
0,8	Contact Elga/ITW	Contact Elga/ITW	50-90	16-18	120-160	22-26
1,0	Contact Elga/ITW	Contact Elga/ITW	80-150	17-20	180-230	24-30
1,2	Contact Elga/ITW	Contact Elga/ITW	110-180	18-22	240-300	26-33
1,6	Contact Elga/ITW	Contact Elga/ITW	110-180	18-22	240-300	26-33