



Elgatig 100

GTAW - TIG
Un-alloyed

| | |
|-----------|------------|
| Date: | 2009-04-23 |
| Revision: | 7 |

Description:

Elgatig 100 is a silicon, manganese double deoxidised welding wire suitable for high integrity TIG welding of mild and medium tensile steels. It is recommended for Si-killed materials.

Welding current:

DC-

Wire composition, wt.%

| | C | Si | Mn | P | S | Cu |
|---------|------|------|------|-------|-------|------|
| Min | 0,07 | 0,80 | 1,40 | | | |
| Typical | 0,08 | 0,90 | 1,50 | 0,010 | 0,015 | |
| Max | 0,14 | 1,00 | 1,60 | 0,025 | 0,025 | 0,30 |

Shielding gas:

I1, Argon, 7-10 l/min

Stamping

F ER70S-6

Chemical composition, wt.%

| | C | Si | Mn |
|---------|------|-----|-----|
| Min | | | |
| Typical | 0,07 | 0,9 | 1,4 |
| Max | | | |

Mechanical properties

| | <u>Specified</u> | <u>Typical</u> |
|-----------------------|------------------|----------------|
| Yield strength, Re: | ≥ 460 MPa | 500 MPa |
| Tensile Strength, Rm: | ≥ 530 MPa | 620 MPa |
| Elongation, A5 | ≥ 22% | 26% |
| Impact energy, CV: | -20 °C • >47 J | -20 °C • 100 J |
| | -46 °C • >27 J | -46 °C • >60 J |

Classification:

EN ISO 636-A W 46 2 W3Si1
AWS A5.18 ER70S-6

Approvals:

DB Kennblatt Nr 42.042.03
TÜV
CE

Product data:

| Ø x Length mm | Packet weight | Product code |
|---------------|---------------|--------------|
| 1,6 x 1000 | 5 kg | 95261016 |
| 2,0 x 1000 | 5 kg | 95261020 |
| 2,4 x 1000 | 5 kg | 95261024 |
| 3,0 x 1000 | 5 kg | 95261030 |