



## F 100S-G

**CODIFICATION:** AWS : SFA 5.28 ER100S-G

### CHARACTERISTICS AND APPLICATIONS:

F 100S-G is a copper-coated solid wire available in bright finish, gives smooth flow, stable arc spatter free under optimum welding conditions. The weld metal displays excellent crack resistance and produces sound weld metal possessing excellent strength combined with good impact properties. It gives radiographic quality welds. It is ideally suited for welding of high strength Q&T steels, like WEL-TEN80, SA 517 SA335 P36 grades, WB36 pipes, and their equivalent grades.

### TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	Cu	Ni	Mo	Cr	Nb	Al	S	P
%	0.08	1.0	0.40	0.60	1.2	0.40	0.20	0.02	0.02	0.014	0.018

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	YS	Elongation
(MPa)	(MPa)	(L=4d) %
720	620	22.0

**SHIELDING GAS:** Argon

**CURRENT CONDITION:** DCEN

**WELDING POSITION:** H, F, VU, OH

**APPROVALS:** Reliance (SASAN Power)

### PACKING:

**STANDARD SIZE:** Diameter 1.6 mm, 2.0 mm, 2.5 mm & 3.2 mm in cut | lengths of 500 mm / 1000 mm each.

**QUANTITY** 5 kg wire put in an air-tight polythene bag and finally packed in a plastic container.  
Identification – AWS code is punched on each wire.