



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