MIG (GMAW) wires
for mild and low alloyed steel

FLIESS SINCE 1915

ED-FK 1

Classification DIN EN ISO	Classification AWS
16834-A G 69 4 M24 Mn3Ni1CrMo	A5.28 ER100S-G, A5.28 ER110S-G
Approvals	**Material No.**
TÜV 03691.05, CE, DB 42.045.04	-

Characteristics and application

MIG/GMAW wire for welding high strength low alloy steels. Used for many structural and construction applications including: mobile cranes, cement pumps, pipelines, tankers and containers.

Base materials

For high strength fine-grained steels with yield strength up to 690MPa (100ksi).
S500Q-S690Q, S500QL-S690QL, P500Q-P690Q, P500QL1-P690QL1
ASTM: A514. HY80, HY100, Q1(N)

Typical analysis in %

C	Si	Mn	Cr	Ni	Mo	V
0,09	0,52	1,57	0,30	1,40	0,25	0,09

Typical heat treatment

Welding procedure, including preheat temperature, interpass temperature and PWHT, will be dependent on the base material being welded and any applicable design codes.

Mechanical properties of the pure weld metal

Yield strength in Mpa	Tensile strength in Mpa	Elongation in %	Charpy-V-Value (ISO-V) in J
≥ 690	≥ 790	4d/5d: ≥ 16	RT ≥ 80 -40°C ≥ 47