

# ES TIG 100S-G

GTAW  
ER100S-G

**ESWECO**  
*The Art of Welding*

## Description

ES TIG 100S-G is a 0.5Cr-0.5Ni-0.2Mo-alloyed, copper-coated rod for the GTAW of high strength steels with a minimum tensile strength of 690 MPa. The rod is also suitable for welding steels where good impact strength at low temperatures is required.

## Current

DC (-)

## Classifications

SFA/AWS A5.28	ER 100S-G
EN 12534	Mn3NiCrMo

## Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo
0.1	0.7	1.4	0.6	0.6	0.2

## Typical mech. Properties all weld metal

Yield stress, MPa	585
Tensile strength, MPa	750
Elongation, %	27

## Charpy V

Test temps, °C	Impact values, J
0	150
-20	85
-40	69

## Welding parameters

Diameter, mm	Length, mm	Weight of rods/box, kg
1.6	1000	5.0
2.0	1000	5.0
2.4	1000	5.0
3.2	1000	5.0