



AWS A5.28: ER100/110S-G
BS EN ISO 16834-A W 69 4 Mn3Ni1CrMo

Solid wire Welding of Fine Grain Steel

MS-100/110S-G

DESCRIPTION & APPLICATION

MIG/TIG Filler Wire for the joining of Fine Grain Steel, rolled, quenched and tempered steel, concrete reinforcing bars, (rebar) High strength low alloy steel tubing. Excellent impact values at sub-zero temperatures.

BASE MATERIALS

BS 4360 WR50A-WR50C. BS 'T' standard RQT 701
Tubing, e.g. T45 Din. 1.8960, 1.8961, 1.8963
ASTM A588 grades A, B, C, K

MECHANICAL PROPERTIES

>790

UTS n/mm

>700

YIELD 0.2%

18

ELONG A5%

>60

CHARPY (J) -20°C

METAL WELD COMPOSITION %

C

0.09

Si

0.6

Mn

1.4

Cu

0.02

Mo

0.25

Ni

1.3

Cr

0.3

Fe

BAL

PACKAGING

15kg and 20kg Spools (MIG)
5kg Tubes (TIG)

DIAMETERS

0.8, 1.0, 1.2mm (MIG)
1.6, 2.4, 3.2mm (TIG)

WELDING INSTRUCTIONS

MIG Shielding Gas 5% or 20% CO₂ in Argon or proprietary mix. TIG 100% Argon. Preheat as per the requirements of the base material. Do not overheat. Allow to cool slowly.