MG 183

Gas Metal Arc (MAG) Welding Wire - High Strength and Low Alloyed Steels

Standards

AWS/ASME SFA - 5.28	ER100S-G
AWS/ASME SFA - 5.28	ER110S-G
EN ISO 16834 - A	G 69 4 M21 Mn3Ni1CrMo
TS EN ISO 16834 - A	G 69 4 M21 Mn3Ni1CrMo

Materials

Width	ASTM
S500Q - S690Q	
S500QL - S690QL	
P500Q - P690Q	
P500QL1 - P690QL1	
	HY80
	Q1(N)
	HY100
	A514

Properties and Applications

Low alloyed wire electrode for GMA (MIG/MAG) welding of fine grained and high strength steels with yield strength of up to 690 N/mm2. Weld metal exhibits good toughness properties down to -40°C. Especially used in high strength pipe-lines, earthmoving and mining equipments, trucks, mobile cranes, concrete pumps cranes and lift productions.

Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Cr	Ni	Mo
Welding Wire	0.09	0.55	1.55	0.30	1.40	0.25

Typical Mechanical Values of Weld Metal

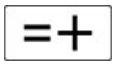
Test Condition	Protection Gas	Yield Strength (N/mm²)	Tensile Strength (N/mm²)	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	M21	710	780	19	-40°C → 65

* Chemical compositon and mechanical properties are valid when using shielding gas EN ISO 14175 - M21 (%82 Ar + %18 CO2) .

Application Information

Welding Positions

Polarity:



Protection Gas:

M21

Welding Parameters & Efficiency

Diameter (mm)
1.00
1.20
1.60

Packaging Information

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
22023DJAM2	1.00	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
22023E2GM2	1.20	400 kg	416.00	1	416.00	Fiber Drum
22023EJAM2	1.20	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
22023GJAM2	1.60	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)

Storage & Re-Drying Information

Shouldn t be exposed to high statical load and impact.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.