

## Low alloy solid wire

### Classification

AWS A5.28 :ER100S-G  
 EN ISO 16834 :Mn3Ni1CrMo

### General Description

Solid wire for GMA welding at high strength steels with yield strength up to 690 N/mm<sup>2</sup>  
 Good impact values at -50°C

### Shielding gases (acc. EN 439)

GMAW M21 Mixed gas Ar+ >5-25% CO<sub>2</sub>  
 C1 Active gas 100% CO<sub>2</sub>

### Approvals

TÜV  
 GMAW +

### Chemical composition (% by mass), typical, all-weld metal

| C    | Mn  | Si   | Cr   | Mo  | Ni   | Cu   | V    | N |
|------|-----|------|------|-----|------|------|------|---|
| 0.08 | 1.7 | 0.44 | 0.23 | 0.3 | 1.35 | 0.25 | 0.08 |   |

### Mechanical properties, all-weld metal

|                              | Process | Shielding gas | Condition | Yield Strength (N/mm <sup>2</sup> ) | Tensile Strength (N/mm <sup>2</sup> ) | Elongation (%) | Impact (ISO), J |
|------------------------------|---------|---------------|-----------|-------------------------------------|---------------------------------------|----------------|-----------------|
| Typical values after welding | GTAW    | M21           | AW        | 710                                 | 790                                   | 20             | -40°C<br>70     |

### Materials to be welded

| Steel              | Code       | Type                         |
|--------------------|------------|------------------------------|
| Pipe material      | API-5LX    | X65, X70, X80                |
|                    | EN 10208-2 | L480, L550                   |
| Fine grained steel | EN 10137-2 | S460, S500, S550, S620, S690 |

### Packaging, available sizes and identification

| Process | Unit:            | Sizes, mm |     |     |
|---------|------------------|-----------|-----|-----|
|         |                  | 0.8       | 1.0 | 1.2 |
| GMAW    | 15 kg spool B300 | X         | X   | X   |

Other sizes and packaging on request

Identification

Imprint: Revis® MoNiVa

Tip colour:

Revis® MoNiVa : rev.EN 20