



Elgatic 101

GTAW - TIG

Un-alloyed

Date: 2009-04-23
Revision: 5

Description:

Elgatic 101 is a silicon , manganese double deoxidised welding wire suitable for high integrity TIG welding of mild and medium tensile steels. It is recommended for Si-killed materials. It has lower levels of Si and Mn than Elgatic 100.

Welding current:

DC-

Wire composition, wt.%

	C	Si	Mn	P	S	Cu
Min	0,06	0,50	0,90			
Typical	0,09	0,65	1,10	0,015	0,013	0,05
Max	0,14	0,75	1,30	0,025	0,025	0,35

Shielding gas:

I1, Ar 99.99%, 7-10 l/min

Stamping

F ER70S-3

Chemical composition, wt.%

	C	Si	Mn
Min			
Typical	0,10	0,60	1,00
Max			

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Re:	≥ 420 MPa	460 MPa
Tensile Strength, Rm:	≥ 500 MPa	560 MPa
Elongation, A5	≥ 20%	26%
Impact energy, CV:	-20 °C • >47 J	-20 °C • 100 J

Classification:

EN ISO 636-A W 42 2 W2Si
AWS A5.18 ER70S-3

Approvals:

CE

Product data:

Ø x Length mm	Packet weight	Product code
1,6 x 1000	5 kg	95271016
2,0 x 1000	5 kg	95271020
2,4 x 1000	5 kg	95271024
3,0 x 1000	5 kg	95271030