

WSG FK1

TIG welding rods for high strength steels

FLIESS
SINCE 1915

Classification DIN EN ISO

16834-A W 69 4 I1 Mn3Ni1CrMo

Material No.

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Classification AWS

A5.28 ER100S-G, A5.28 ER110S-G

Approvals

CE

Characteristics and application

TIG/GTAW wire for welding high strength low alloy steels. Used for many structural and construction applications including: mobile cranes, cement pumps, pipelines, tankers and containers.

Base materials

For high strength fine-grained steels with yield strength up to 690MPa (100ksi).

S500Q-S690Q, S500QL-S690QL, P500Q-P690Q, P500QL1-P690QL1

ASTM: A514, HY80, HY100, Q1(N)

Typical analysis in %

C: 0,09

Si: 0,52

Mn: 1,57

Cr: 0,30

Ni: 1,40

Mo: 0,25

V: 0,09

Yield strength in Mpa

≥ 690

Tensile strength in Mpa

≥ 790

Elongation in %

4d/5d: ≥17

Charpy-V-Value (ISO-V) in J

-40°C ≥47

Typical heat treatment

Welding procedure, including preheat temperature, interpass temperature and PWHT, will be dependent on the base material being welded and any applicable design codes.

Other products

MIG/GMAW: ED-FK1, ED-ER110S-1, ED-FK800

TIG/GTAW: WSG ER100S-1, WSG ER110S-1

SAW: UP-EM2, UP-EM4, UP-101 S3NiCrMo2,5