



# Elgatig 135

GTAW - TIG

Low-alloyed

Date:	2007-10-08
Revision:	6

## Description:

Elgatig 135 is a 1.5% Ni / 0.5% Mo / 0.2% Cr alloyed wire intended for TIG welding the high tensile quenched and tempered steels such as Weldox 700, BSC RQT 701, N-A-XTRA 70 and USST1. The weld deposit has good fracture toughness at temperatures down to -40°C.

## Welding current:

DC-

## Wire composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,40	1,30			0,20	1,20
Typical	0,10	0,55	1,65	0,012	0,013	0,35	1,35
Max	0,12	0,70	1,80	0,015	0,018	0,40	1,60

	Mo	Cu	V
Min	0,20		0,05
Typical	0,25	0,06	0,10
Max	0,30	0,35	0,13

## Shielding gas:

I1, Argon, 7-10 l/min

## Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min							
Typical	0,08	0,45	1,30	0,010	0,010	0,18	1,30
Max							

	Mo	V
Min		
Typical	0,25	0,09
Max		

## Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Re:		700 MPa
Tensile Strength, Rm:	≥ 690 MPa	790 MPa
Elongation, A5		20%
Impact energy, CV:		-40°C • 55 J

## Classification:

EN ISO 16834  
AWS A5.28

W 69 4 Mn3Ni1CrMo  
ER100S-G

## Approvals:

## Product data

Diam.mm	Length mm	Product code
1,6	1000	9537-1016
2,4	1000	9537-1024