

ZULFI SW ER100S-G

CLASSIFICATION

AWS A5.28 ER100S-G

APPROVALS

ABS
BV
DNV
LRS

GRADE

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PROPERTIES

ZULFI SW ER100S-G is a precision layer wound copper coated CO₂ wire having highest combination of manganese and silicone deoxidizers. Higher levels of de-oxidizers make it suitable for applications where dirt, rust or mill-scale is present. It permits high current welding with CO₂ gas shielding, and it can also be applied with ArCO₂ shielding as well. It is good for out-of-position welding using short circuiting transfer. Controlled cast and layer wound makes this wire have very smooth feeding without any disturbance even with high-speed robotic welding.

APPLICATIONS

It is widely used for welding structures fabricated by 690-720MPa grade tensile strength low alloy steels of X80, WH590, DB590, such as heavy trucks, high pressure vessels, industrial boilers, engineering & construction machineries, handling equipment's, pipelines and so on.

CHEMICAL ANALYSIS [TYPICAL VALUES IN %]

CONDITION	C	Mn	Si	Cu	Ni	Mo	P	S
Wire	0.08	1.45	0.70	0.10	1.30	0.45	0.015	0.015
Weld metal (100% CO ₂)	0.09	1.20	0.40	0.064	1.25	0.40	0.013	0.013

CURRENT CONDITION & WELDING POSITION

DC+

ALL-WELD METAL MECHANICAL PROPERTIES

CONDITION	YIELD STRENGTH (MPa)	TENSILE STRENGTH (MPa)	ELONGATION %	IMPACT STRENGTH
As welded (100% CO ₂)	≥ 620	700 - 760	≥ 20	50J at -40 °C

PACKING DATA

DIAMETER (MM)	VOLTAGE (V)	CURRENT (A)	GAS FLOW RATE (LPM)	STICK OUT (MM)	WEIGHT PER SPOOL (KG)
0.80	17-27	80-250	12-18 (100% CO ₂) 17-22 (ArCO ₂)	10-20	15
1.0	18-30	100-350			15
1.20	20-34	120-400			15
1.60	22-36	150-450			15