

IABCO FK1 TIG

TIG/GTAW wire for low alloy high strength steels

Product name	IABCO FK1 TIG
Classification EN ISO	16834-A: W Mn3Ni1CrMo / W 69 4 Mn3Ni1CrMo
Material No.	-
Classification AWS	A5.28: ER100S-G / ER110S-G
Approvals	CE.
Applications	TIG/GTAW wire for welding high strength low alloy steels. Used for many structural and construction applications including: pipelines, tankers and containers.
Base materials	For high strength fine-grained steels with yield strength up to 690MPa (100ksi). ASTM: A514, HY80, HY100, Q1(N). S500Q-S690Q, S500QL-S690QL, P500Q-P690Q, P500QL1-P690QL1.
Typical analysis of wire, weight %	C: 0.09 Si: 0.52 Mn: 1.57 Cr: 0.30 Ni: 1.40 Mo: 0.25 V: 0.09
Typical heat treatment ⁽¹⁾	Welding procedure, including preheat temperature, interpass temperature and PWHT, will be dependent on the base material being welded and any applicable design codes.
Mechanical properties of weld deposit ⁽²⁾	M21 shielding gas: 0.2% proof stress, Rp0.2%: ≥690MPa. Tensile strength, Rm: ≥790MPa. Elongation, 4d/5d: ≥17%. Impact ISO-V, -40°C: ≥47J.
Other products	SAW: S3 NiCrMo2.5 MIG/GMAW: FK1.

Notes (1) Application codes and project specifications should always be referred to for specific requirements.

(2) Actual mechanical properties will be dependent on specific welding procedure (including shielding gas, flux, PWHT etc) and should always be confirmed by approval of an appropriate welding procedure.