

Inweld 100S-1

AWS A5.28 ER100S-1

Chemical Composition of Inweld 100S-1

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	V	Cu	Ti	Zr
Balance	0.08	0.30	1.4- 2.1	0.25- 0.55	1.25- 1.80	0.20- 0.55	0.01	0.01	0.05	0.25	0.10	0.10

Single values are maximum unless otherwise specified.

Description and Applications

Inweld 100S-1 filler metal deposits high-strength, very tough weld metal for critical applications. Originally developed for welding HY80 & HY100 steels for military applications, it is also used for a variety of structural applications where tensile strength requirements exceed 100 ksi (690 MPa), and excellent toughness is required to temperatures as low as -60°F (-51°C). Mechanical properties obtained from weld deposits made with electrodes of this classification will vary depending on the heat input used.

Typical Weld Metal Properties

	AWS Spec
Tensile Strength:	100,000 psi
Yield Strength:	88,000 psi
Elongation:	16%

Recommended Parameters

GMAW (DCEP - Electrode+) 100 % CO₂, or a 75-25% Argon/CO₂ Mixture For Solid Wire, 98 % Argon / 2% CO₂ Mixture For Spray Transfer

Wire Diameter	Voltage	Amperage	Wire Feed IPM
0.035"	22-25	100-140	320-510
0.045"	23-26	120-150	170-550
0.035" (Spray)	28-32	160-200	320-510
0.045" (Spray)	30-34	280-220	170-550

GTAW (DCSP) 2% Thoriated Tungsten Electrode Negative

Tungsten Dia.	Filler Wire Size	Amperage	Argon (CFH)
1/16"	1/16"	100-160	20
3/32"	3/32"	120-250	20
1/8"	1/8"	150-300	25

INWELDCORPORATION.COM

Pennsylvania
3962 Portland Street
Coplay, PA 18037

North Carolina
1029 S. Marietta St.
Gastonia, NC 28054

Texas
9300 Lawndale St.
Houston, TX 77012

California
6201 Coliseum Way, Unit A
Oakland, CA 94621