MIGWELD 690

MIG/MAG Wires [GMAW]

Construction, unalloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 16834-A : G 69 4 M21 Mn3Ni1CrMo AWS A-5.28 : ER 100 S-G	TUV	Constructions & Engineering Mining

- Welding wire with the addition of Ni, Cr and Mo for finegrained high tensile strength steels up to 690 MPa yield strenght.
- Used for many applications in constructions, including: mobile cranes, concrete pumps, piping, mining equipment, tanks.

Application

Multiple applications in constructions, such as mobile cranes, concrete pumps, pipelines, mining equipment, cisterns, tanks.

Base material

	EN	DIN, AISI	
Fine grain steels	S420N, S500N, S420NL, P420NH-P500NH, S690QL, S690Q, L690L	StE 420-StE500, TStE420, WStE420-WStE500, TStE690V, StE690.7	
Heat-treated fine grain steels	S550QL1, S620QL1, S690QL1	N-A-XTRA56, N-A-XTRA63, N-A-XTRA70, T1, T1A, T1B, HSB77V, Weldox 700, BH70V Hy90, Hy100, Welten 80, Bisalloy 80	
Pipelines	L485MB, L555MB	X60, X65, X70, X80	

Typical chemical composition %

C	Si	Mn	Cr	Ni	Mo
0,08	0,60	1,70	0,25	1,50	0,30

Typical mechanical properties

Yield strength Re [N/mm2]	>690
Tensile strength Rm [N/mm2]	770-940
Elongation A5 [%]	17
Impact energy Kv [J]	≥ 47J (-40°C) /
Wire/rod type	solid
Welding current	
Welding positions	
Shielding gases acc. to EN ISO 14175	M21 - Ar + 15 - 25% CO2 /

Welding parameters and packing

⌀	Weight of packet [kg]
1,0	15,0
1,2	15,0

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