

MIGWELD 690

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MIG/MAG WIRES
(GMAW)**CLASSIFICATION:**EN ISO 16834-A: G 69 4 M21 Mn3 Ni1 CrMo
AWS A-5.28: ER 100 S-G**APPROVALS:**

TUV

DESCRIPTION:

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

APPLICATION:

For welding cranes and mobile cranes, pipelines, tankers and container ships, mining machinery

BASE MATERIAL:

	EN	DIN, AISI
Fine grain steels	S420N, S500N, S420NL, P420NH-P500NH, S690QL, S690Q, L690L	StE 420-StE500, TSStE420, WStE420-WStE500, TSStE690V, 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 0,08 Si 0,60 Mn 1,70 Cr 0,25 Ni 1,50 Mo 0,30

TYPICAL MECHANICAL PROPERTIES:

Re: >690 N/mm²
Rm: 770-940 N/mm²
A5: 17%
Kv: ≥ 47J (-40°C)

Wire type: solid



Shielding gases acc. to EN ISO 14175:
M21: Ar + 15-25% CO₂

Welding parameters	Packing
φ	Weight of packet [kg]
1,0	15,0
1,2	15,0

Read more about this product: <https://www.metalweld.pl/en/migweld-690>

GMAW wires for low alloyed, medium alloyed and high strength steels