



## Nexus 1NiMo

NiMo wire for MIG welding very high strength low temperature steels

Low alloy copper coated solid MIG wire for joining and overlaying materials of similar compositions.

### International Standards

|                       |               |
|-----------------------|---------------|
| ISO 16834 - A - :2007 | AWS A5.28- 05 |
| GMn3Ni1Mo             | ER100S-G      |

### Typical Wire Analysis (wt%)

| C    | Si   | Mn   | S    | P    | Ni  | Mo   |
|------|------|------|------|------|-----|------|
| 0.08 | 0.57 | 1.77 | 0.02 | 0.02 | 0.9 | 0.38 |

### Typical All-Weld Metal Mechanical Properties

| Yield Strength<br>N/mm <sup>2</sup> | Tensile Strength<br>N/mm <sup>2</sup> | Elongation<br>% | Impact Strength<br>-50°C |
|-------------------------------------|---------------------------------------|-----------------|--------------------------|
| ≥640                                | ≥710                                  | ≥18             | ≥47J                     |

### Welding Positions

|                                       |
|---------------------------------------|
| All Positions including vertical down |
|---------------------------------------|

### Materials

|   |
|---|
| S690QL1, S420N-S500N, P420NH-P500NH and S420NL-S500NL |
|---|

### Packaging

| Size mm              | 0.8 | 1.0 | 1.2 |
|----------------------|-----|-----|-----|
| Metal spools 15 kilo | ✓   | ✓   | ✓   |

### Additional Information

|                            |   |
|----------------------------|---|
| Certification              | BS EN 10204:2004 Type 3.1                               |
| Material safety data sheet | MSDS 11   |
| BOC Shielding Gas          | Argoshield Light (<4mm) Universal (2-10mm) Heavy (>9mm) |