

TECHNICAL DATA

Standards

DIN Material Nr. 1.4937

EN ISO 16834-A :	G 62 4 M21 Mn3Ni1Mo)
AWS A5.28 :	ER100S-G

General Properties / Field of Applications

DSI M 93Plus is a martensitic Laser Welding Wire made of low-alloy steel tempered fine-grain structural steels up to a yield strength of a yield strength of 620 MPa. Weld metal for operating temperatures from -40 to +350°C.

Mechanical Properties

Yield strength Rp0.2	[MPa] / [N/mm ²]	680
Tensile strength Rm	[MPa] / [N/mm ²]	750
Elongation A (L0 = 5d0)	[%]	21
Maximum operating temp.	[°C]	-40 to +350

Chemical Composition (Standard Values in %)

C	Si	Mn	Ni	Mo
0.1	0.7	1.7	1.1	0.4

Compatible Materials (Selection)

S500Q-S620Q / 20MnMoNi5-5 (1.6310) / 11NiMoV5-3 (1.6341) / API 5 L X70, X70Q
G24Mn6 / ASTM A 572 Gr. 65 / A 633 Gr. E / 15NiCuMoNb5-6-4

Packaging and available Sizes*

Spool : MA125 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2
Rod : 500 / 1000 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2

* Other dimensions available on request

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