


CATEGORY	GMAW Solid wires						
TYPE	Extreme high tensile strength alloy with excellent impact properties for fine grain steels exceeding 890 N/mm ² yield strength.						
APPLICATIONS	Welding materials such as S960QL – S1100Q and other similar fine grain cold tough steels. Offshore, crane building etc.						
PROPERTIES	Extreme crack resistant alloy with high mechanical properties and excellent welding characteristics. High Impact strength at sub zero temperatures down to -60 °C. Applications include structural, oil and gas and offshore steelwork.						
CLASSIFICATION	AWS	A 5.28: ER 120S-G					
	EN ISO	16834-A: G 89 5 M Mn4Ni2,5CrMo					
	F-nr	6					
	FM	2					
SUITABLE FOR	XABO 90, StE890V, StE960TM, Weldox 700, weldox 900, Domex 960, Domex Wear 360, StE 890, S890QL1, A517, X120, StE 960, S960QL1, S1100 (till 12 mm)						
APPROVALS	CE						
WELDING POSITIONS:							
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)							
C	Si	Mn	P	S	Cr	Ni	Mo
0.1	0.6	1.8	0.01	0.01	0.3	2.2	0.6
ALL WELD MECHANICAL PROPERTIES							
Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V -60°C			
As Welded /	900	960	15	50			
WELDING PARAMETERS / PACKING							
REDRYING TEMPERATURE	Not required						
GAS ACCORDING EN 14175	M21						