

CATEGORY GTAW Solid wires

TYPE Extreme high tensile strength alloy with excellent impact properties for fine grain steels exceeding 890 MPa yield strength.

APPLICATIONS Welding materials such as S960QL – S1100Q and other similar fine grain cold tough steels. Offshore, crane building etc.

PROPERTIES Extreme high tensile strength alloy with very good mechanical properties and perfect welding characteristics. High impact strength at very low temperatures with exceptional plasticity of the weld deposit. Weldable with Co2 and Mix gas.

CLASSIFICATION	AWS	A 5.28: ER 120S-G
	EN ISO	16834-A: W 89 5 I1 Mn4Ni2CrMo
	F-nr	6
	FM	2

SUITABLE FOR XABO 90, StE890V, StE960TM, Weldom 700, weldox 900, 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	Cr	Ni	Mo
0.08	0.6	1.8	0.3	2.25	0.55

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V -60°C
As Welded /	980	1090	18	50

WELDING PARAMETERS / PACKING

WELDING PARAMETERS		WELDING PARAMETERS	PACKING (KG)	PACKING (KG)
D (MM)	CURRENT (A) DC-		SINGLE	MASTER
1,6 X 1000	50-80		5	25
2,4 X 1000	110-180		5	25
3,2 X 1000	150-280		5	25

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175 I1