



Coppered welding wire

Classifications: AWS A5.28-96: ER 120 S-G
EN ISO16834-A G89 4 M Mn 4 Ni2.5 Cr Mo

Main features :

Mild steel low alloyed Ni-Cr-Mo welding wire used for welding under protective gases. Preferred gas mix is Ar /Co2 , but can even be used with pure Co2 gas. This low alloy wire is manufactured to weld high strength steels with tensile strength higher than 900MPa. Excellent impact strength at low temperatures. Suitable for the metal working industry, offshore fabrications, chemical and petrochemical industries. It has wide applications also in fabrication of HSLA (high strength low alloy) used in industrial machineries constructions, cranes and other highly stressed structural components.

Chemical analysis %

C	0.08 - 0.13	Ni	1.90 – 2.30
Mn	1.70 - 1.90	Cr	0.30 - 0.50

Si	0.60 - 0.85	Mo	0.45- 0.55
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S	0.025	Cu	< 0.25
P	0.025	V	< 0.10

Power	STEEL:
DC +	Weldox 960 D

Gas

Ar / CO₂ - Ar / CO₂ / O₂ - CO₂ (EN 439: M2, C1)

Mechanical Properties

Gas Mix	(Tensile strength) Rm N/mm ²	(Yield strength) Re N/mm ²	(Elongation) A5 (%)	Kv J - 20°C
Ar / CO ₂ (M21)	>890	900-1030	14-18	>70

WELDING POSITIONS:

