

Classifications

EN ISO 16834-A	AWS A5.28
G 89 5 M21 Mn4Ni2,5CrMo	ER120S-G

Characteristics and typical fields of application

Low-alloyed solid wire electrode for shielded arc welding of quenched and tempered fine grained structural steels in crane and vehicle manufacturing. Good deformability in spite of very high strength values. Good resistance to cold cracking due to high purity of the wire surface.

Base materials

S960QL (alform 960; Dillidur 960; Weldox 960; XABO 960),
S890QL (Dillidur 890; Weldox 890; XABO 890),
S890MC (alform 900 M; Domex 900)
S960MC (alform 960 M; Domex 960)
OX 1002

Typical analysis of solid wire (wt.-%)

	C	Si	Mn	Cr	Mo	Ni
wt-%	0.12	0.80	1.90	0.45	0.55	2.35

Mechanical properties of all-weld metal

Heat-treatment	Shielding gas	Yield strength	Tensile strength	Elongation	Impact work	
		R _{p0.2}	R _m	A (L ₀ =5d ₀)	ISO-V KV J	
		MPa	MPa	%	+20 °C	-50 °C
aw	M21	930	980	14	80	47

Operating data

	Polarity:	Shielding gas:	ø mm	Spool:
	DC (+)	(EN ISO 14175)	0.8	B300
		M2	1.0	B300
			1.2	B300

Approvals

DB (42.132.26), CE