


ER 120 S-1

CATEGORY	GMAW-GTAW 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 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 Co ₂ and Mix gas.																																						
CLASSIFICATION	AWS	A 5.28: ER 120 S-1																																					
	EN ISO	16834-A: G 89 5 M Mn4Ni2,5CrMo																																					
	DIN: W.Nr.	1.8983																																					
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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)																																						
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WELDING POSITIONS:																																							
WELD METAL ANALYSIS ACC. AWS IN WEIGHT %	<table border="1"> <thead> <tr> <th>C</th> <th>Mn</th> <th>Si</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>Cu</th> <th>Ti</th> <th>Zr</th> <th>Al</th> </tr> </thead> <tbody> <tr> <td><0.1</td> <td>1.4-1.8</td> <td>0.25-0.60</td> <td><0.6</td> <td>2.0-2.8</td> <td>0.30-0.65</td> <td><0.25</td> <td><0.10</td> <td><0.10</td> <td><0.10</td> </tr> </tbody> </table>									C	Mn	Si	Cr	Ni	Mo	Cu	Ti	Zr	Al	<0.1	1.4-1.8	0.25-0.60	<0.6	2.0-2.8	0.30-0.65	<0.25	<0.10	<0.10	<0.10										
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