

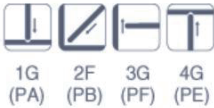
ER120S-G

AWS A5.28 ER120S-G

Description:

ER120S-G is cooper coated low alloy solid wire for welding high strength steels with yield strength up to 890MPa. Can be used as well as for welding grade S960 and featured with good impact toughness value down to -60° C

Welding Position:



Diameters:

1.2mm

Typical Mechanical Properties:

Tensile strength(MPa):	950
Yield strength(MPa):	850
Elongation(%):	15
Impact values(≥27)/-40℃):	72

Typical Chemical Composition:

C	Mn	P	S	Si	Mo	Cr	Ni
0.09	1.80	0.010	0.012	0.80	0.55	0.30	2.20

Welding Current:

Diameter(mm)		1.0	1.2	1.6
Current/A	F/H	80-250	100-360	170-390
Current/A	V/OH	80-160	80-220	--

Note:

- 1, Rusty, water, oil and other impurity should be cleaned before welding.
- 2, Shield gas: 100%CO₂ or 80%Ar+20% CO₂.
- 3, Gas speed: 15-25L/Min

4. Tig rods ER120S-G 1.6mm, 2.0mm, 2.4mm, 3.2mm available