



**TecMig**  
The pro's choice

**ER120S-G**

LOW ALLOY HIGH TENSILE SOLID WIRES

## CHARACTERISTICS

- 1, Excellent mechanical properties
- 2, Good anti-crack performance
- 3, Good weldability including stable arc, minimum spatters and uniform bead formation

## TYPICAL APPLICATIONS

- 1, High-rise building with high earthquake resistant requirement
- 2, Bridges
- 3, Engineering machinery



| SIZE  | AMPS     |
|-------|----------|
| 1.2mm | 90-350A  |
| 1.6mm | 170-390A |

## CHARACTERISTICS

AWS A5.28 ER120S-G  
EN ISO 16834-A-G 69 4 M21 Z

## WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G

## EQUIVALENT TO

## CHEMICAL COMPOSITIONS (Wt%), ALL WELD METAL, TYPICAL

| C    | Si   | Cr   | Mn   | Mo   | Ni  | P     | S     |
|------|------|------|------|------|-----|-------|-------|
| 0.08 | 0.54 | 0.32 | 1.72 | 0.35 | 0.7 | 0.008 | 0.009 |

## AVAILABLE SIZES (DIA.)

1.2mm/1.6mm

## PACKAGING DETAILS

15kg Spools ,250/350kg Drums

## CURRENT TYPE

DC+

## MECHANICAL PROPERTIES, ALL WELD METAL, TYPICAL

| Condition | Shielding Gas              | Yield Strength (mpa) | Tensile Strength (mpa) | Elongation(%) | Charpy V notch (J) |
|-----------|----------------------------|----------------------|------------------------|---------------|--------------------|
| AW        | 80% Ar+20% CO <sub>2</sub> | 745                  | 862                    | 17            | -40°C 70           |

Note:  
Shielding gas: 80% Ar+20% CO<sub>2</sub>

TM WELDING (WUHAN) CO.,LTD [www.tecmig.com](http://www.tecmig.com)

