

CLASSIFICATIONS

EN ISO 16834-A : G 89 4 M21 Mn4Ni2,5CrMo

AWS A5.28 : ER 120S-G

DESCRIPTION

- Fine grained steels, high yield strength, austempering steels excellent properties low temperatures
- Lifting and handling machines, bridges, tanks, transport, shipbuilding, railway sector, mines, cranes, frames, etc
- Shielding gas: Ar+CO₂ mix gases can be used

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.10 | Si:0.55 | Mn: 1.70 | Ni: 2.50 | Mo: 0.50 | Cr: 0.30 | Cu: 0.20

MECHANICAL PROPERTIES

Yield Strength (MPa)	Tensile Strength (MPa)	Impact Strength (ISO-V/-40°C)	Elongation (L _o =5d _o) (%)
min. 890	940 - 1180	min. 47 J	min. 15

BASE MATERIALS

- S890QL , P460NH , P460NL1,
- WELDOX 900, StE 960, S960Q

WELDING POSITIONS



CURRENT CONDITION

MAG D.C.(+)

OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
1011100008	1.00	0.040"	15	BS 300 Spool
1011100009	1.20	0.047"	15	BS 300 Spool