# AS MIG 120SG

## MIG/MAG Welding Wire for High Strength and Low Alloyed Steels

### Classification

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

### General Description

It is a low alloyed GMA welding wire, used for the welding fine-grained and high strength steels with a yield strength up to 960 N/mm. It gives a weld metal that is used in operating temperatures down to – 40°C with a high toughness value. Especially used for low temperature applications that are manufactured from Ni-Cr-Mo steels.

**Industry:** Ship building, petro-chemical, construction, crane and bridge fabrication industry.

### Chemical Composition (w%), Typical, Wire

| C | Si | Mn | Ni | Cr | Mo | V | Cu |
|---|---|---|---|---|---|---|---|
| 0.10 | 0.66 | 1.80 | 2.45 | 0.38 | 0.47 | 0.06 | < 0.20 |

### Mechanical Properties, Typical, All Weld Metal

Yield Strength : 960 N/mm²
Tensile Strength : 1040 N/mm²
Elongation (L=5d) : 16 %
Impact (ISO-V) : 60 J (-40°C)

### Gaz de protection (ISO 14175 / EN 439)

MIG: M21- Ar + 5-25% $CO_2$
C1 - $CO_2$ (100%)

Current Type and Polarity : DC (+)

### Materials to be Welded

| | DIN | EN |
|---|---|---|
| **Fine Grained Steels** | StE 960 - | S960Q<br>S890QL<br>P460NH<br>P460NL1 |
| **Heat Treated Fine Grained Structural Steels** | | Weldox™ 800<br>Weldox™ 900<br>Weldox™ 960D<br>Weldox™ 960E |

### Packing and Diameter Informations

| Diameter | 0.8 | 1.0 | 1.2 | 1.6 | 2.0 | 2.4 | 3.2 | Spool Weight |
|---|---|---|---|---|---|---|---|---|
| MIG/MAG Wire | - | x | x | - | - | - | - | 15 kg |