

Classifications

EN ISO 16834-A		AWS A5.28	
G 89 6 M Mn4Ni2CrMo		ER120 S-G	

Characteristics and typical fields of application

Solid copper coated wire for welding of quenched and tempered fine grained structural steels, with yield strength higher than 890 and 960 Mpa, in crane and vehicle manufacturing, using Argon-CO₂ as shielding gas. We suggest to weld with low heat input to achieve the best mechanical properties, keeping an interpass temperature of maximum 150°C.

Base materials

USS-T1 S890QL (Dillidur 890;Weldox 890;XABO 890); S960QL (Alform 960 M; Dillidur 960;XABO 960); S890MC (Alform 900 M; Domex 900); S960MC (Alform 960; Domex 960)

Typical analysis of all-weld metal (wt.-%)

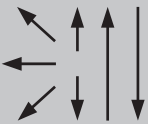
C	Mn	Si	Mo	Cr	Ni	GAS
0.09	1.90	0.80	0.60	0.30	2.30	M21

Mechanical properties of all-weld metal – typical values (minimum values)

Condition	Heat-treatment	Yield strength R _{p0.2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work in J CVN	
		MPa	MPa	%	RT	-60°C
u	AW	890	950	15	90	47

u: untreated, as welded – shielding gas Ar + 18% CO₂

Operating data

	Ø (mm)	Spool	Weight (Kg)	Current A	Voltage V
	1.00	B300	16	45 - 270	15 - 32
	1.20	B300	16	50 - 300	16 - 33
	1.40	B300	16	60 - 350	20 - 34
	1.60	B300	16	65 - 390	20 - 35

Other spool types on request.

Approvals

TÜV (11917)