

SM-120 (HD)

AWS A5.28/ ASME SFA5.28 ER120S-G

EN ISO 16834-A-G Mn4Ni2,5CrMo



❖ Specifications

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❖ Descriptions

Gas shielded welding wire suitable to join high strength and Cr-Ni-Mo-V low alloy steels
MIG/MAG (GMAW) gas shielded welding wires of high strength steels and fine-grained
Structural steels with a yield strength of up to 890 Mpa

❖ Chemical composition

C	Mn	Si	P	S	Cr	Ni	Mo	Cu	V
0.08	1.60	0.60	-	-	0.20	1.80	0.45	-	-
0.10	2.10	0.90	0.015	0.018	0.45	2.30	0.70	0.30	0.03

❖ All Weld Metal Mechanical Properties

Tensile Test			CVN Impact Test (Joule)	
YS(MPa)	TS(MPa)	El(%)		
≥ 890	≥ 940	≥ 16	-40℃	≥ 47

Gas protection : ISO 14175 M21 mixture

❖ Package

SM-120 (HD) (GMAW)	Size (mm)	0.8	1.0	1.2	1.4	1.6
	Weight	Spool : 15, 16, 18 kg / Drum : 250, 350, 450 kg				