

Low alloy solid wire

Classification

AWS A5.28 :ER120S-G
 EN ISO 16834-A :G 89 4 M Mn4Ni2CrMo

General Description

Copperplated wire for welding of high strength, heat-shielded and fine-grained structural steels with a minimum yield strength of 890 N/mm².

Shielding gas (acc. EN 439)

GMAW M21 Mixed gas Ar+ 15-25% CO₂
 C1 Active gas 100% CO₂

Approvals

GMAW TÜV CE
 + +

Chemical composition (% by mass), typical, all-weld metal

C	Mn	Si	Cr	Mo	Ni
0.1	1.8	0.8	0.3	0.5	2.0

Mechanical properties, all-weld metal

	Process	Shielding gas	Condition	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation (%)	Impact (ISO), J -40°C
Typical values after welding	GMAW	M21	AW	890	940-1180	15	80

Materials to be welded

Steel	Code	Type
Pipe material	API-5LX	X65, X70, X80
Fine grain steel	EN 10137-2	S890Q, OX 1002

Packaging, available sizes and identification

Process	Unit:	Sizes, mm	
		1.0	1.2
GMAW	15 kg spool B300	X	X

Other sizes and packaging on request

Identification

Imprint: Revis[®]120S-G

Tip colour:

Revis[®]120S-G: rev.EN 20