

Classifications

AWS A5.28-05	: ER120S-G
EN ISO 16834-A:2007	: W 69 6 M Z
EN ISO 16834-B:2007	: W 83A 6 U M 0
JIS Z 3312	: W 78 A 6 M 0

Description

- For MAG welding of 830MPa high tensile steel used for pipe line, offshore, structure, construction machinery, pressure vessels
- Welding materials such as S960QL – S1100Q and other similar fine grain cold tough steels.
- Proper tungsten electrode extension from the tip of torch is 4-6mm in general.

Typical chemical composition of rod (%)

C	Si	Mn	P	S	Ni	Mo
0.06	0.50	1.45	0.002	0.003	3.40	0.55

Typical mechanical properties of all-weld-metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -60°C	Remarks
AWS A5.28	-	min. 830	14	-	As weld, Ar
EN 16834-A	min. 600	770-940	18	≥47	As weld, Ar
EN 16834-B	min. 745	830~1,030	12	≥47	As weld, Ar
Example	840	920	20	170	As weld, Ar

Operating data

Dia.(mm)	Voltage	Ampere
0.9	10~12	50~70
1.2	10~12	70~100
1.6	12~15	100~125
2.4	15~20	125~175
3.2	15~20	175~200

Polarity and Shielding gas

- DCEN (DC-)
- Ar : 100%Ar (15~25ℓ/min.)