

Standards
**Chemical Composition of
Welding Wire % (Typical)**

TS EN ISO 16834-A	: G 89 4 M21 Mn4Ni2,5CrMo
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AWS A5.28	: ER 120S-G

C	Si	Mn	Mo	Ni	Cr	Cu
0.11	0.70	1.90	0.50	2.50	0.50	<0.25

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-40°C)	Elongation ((L ₀ =5d ₀) (%))
960	1040	min. 47 J	min. 16

Typical Base Material Grades

- S890QL, S960Q; P460NH, P460NL1; WELDOX 900, WELDOX 960, Strenx 960

Features and Applications

- Fine grained steels, high yield strength, austempering steels excellent properties low temperatures
- Lifting and handling machines, bridges, tanks, transport, shipbuilding, railway sector, mines, cranes, frames, etc
- Shielding gas: MAG: (Ar+% 15-25 CO₂)

Welding Positions

Current Type

MAG D.C.(+)

Operating Data

Product Code	Diameters (mm) / (inch)	Weight (Kg)	Package Type
3031100212	1.00	15	BS 300
3031100211	1.20	15	