

GETIG 120SG

IDENTIFICATION

Getig 120SG, ER 120SG

CLASSIFICATION

AWS A5.28/ASME SFA5.28: ER 120SG

DESCRIPTION

Solid wire for TIG welding of high strength fine grain steel. The wire is alloyed with alloying elements like Nickel, Chromium and molybdenum and deposits high tensile weld metal having UTS of more than 780 MPa.

CHEMICAL ANALYSIS (RANGE) %

C	Si	Mn	Ni	P	S	Mo	Cr	Cu
0.07 max	0.45 max	1.75 max	2.10 max	0.012 max	0.010 max	0.50 max	0.30 max	0.25 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	EL (%)	CVN Impact Value	
			Temp	Joules
860 min	760 min	19 min	-40°C	75

TYPICAL APPLICATIONS

For welding fine grain steel such as HY80, HY100, N-A-XTRA 65-70, USS-T1, XABO-90, ST E885 etc.

SPECIAL INSTRUCTIONS

- 100% Pure Argon gas for shielding
- Flow quantity of shielding gas should be 25 liters/minute, approximately.
- Use wind screen against wind.

SHIELDING GAS : 100% Pure Argon

WELDING CURRENT : DC (+)

PACKING PARAMETERS

Size (mm)	Length (mm)	Packing / Pkt (kg)	Packing / Box (kg)
1.6	1000	5	5 x 4 = 20
2	1000	5	5 x 4 = 20
2.40 / 2.50	1000	5	5 x 4 = 20