

# GM 120SG

## IDENTIFICATION

GM 120SG, ER120SG

## CLASSIFICATION

AWS A5.28/ASME SFA5.28: ER 120S-G

## DESCRIPTION

- Solid wire for gas-shielded metal arc 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 860 MPa.

## CHEMICAL ANALYSIS (RANGE) %

C	Si	Mn	Ni	P	S	Mo	Cr	Cu
0.07 max	0.45 max	1.60 max	1.60 max	0.012 max	0.010 max	0.30 max	0.15 max	0.25 max

## MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	PS (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

- Use 80% Ar + 20% CO2 gas for shielding
- Flow quantity of shielding gas should be 25 liters/minute, approximately.
- Use wind screen against wind.

**WELDING CURRENT :** DC (+)

**SHIELDING GAS :** 80% Ar + 20% CO2 OR Ar + 5 - 20% CO2

## RECOMMENDED CURRENT (AMPS)

Size (mm)	F & HF
1.2	200~350
1.6	300~550

## PACKING PARAMETERS

Size (mm)	Weight / Spool (kg)
1.2	15

