

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 |

