

ST-120

AWS A5.28/ ASME SFA5.28 ER120S-G

EN ISO 16834-A-G Mn4Ni2,5CrMo



❖ Specifications

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❖ Descriptions

Gas shielded welding wire suitable to join high strength and Cr-Ni-Mo-V low alloy steels
TIG gas shielded welding wires of high strength steels and fine-grained Structural steels
with a yield strength of up to 910 MPa

❖ Chemical composition

C	Mn	Si	P	S	Cr	Ni	Mo	Cu	V
0.08	1.60	0.60	-	-	0.20	1.80	0.45	-	-
0.10	2.10	0.90	0.015	0.018	0.45	2.30	0.70	0.30	0.03

❖ All Weld Metal Mechanical Properties

Tensile Test			CVN Impact Test (Joule)	
YS(MPa)	TS(MPa)	El(%)		
≥ 910	≥ 960	≥ 16	-40℃	≥ 100

Gas protection : ISO 14175 M21 mixture

❖ Package

ST-120 (TIG)	Size (mm)	1.6	2.0	2.4	3.2	4.0
	Weight	5 KG				