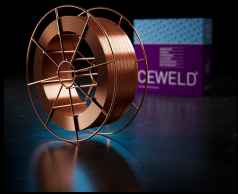


CEWELD ER 120 S-1

TYPE	Extremely high-strength solid wire with excellent notched impact strength properties for fine-grain steels with a yield strength up to 960 MPa. (ER 120 S-1)							
APPLICATIONS	CEWELD ER 120-S1 is designed for welding S720QL - S960Q and other similar fine-grained cold-working steels. Offshore, crane construction etc.							
PROPERTIES	CEWELD ER 120-S1 have a Extreme high tensile strength alloy with very good mechanical properties and perfect welding characteristics. High impact strength at very low temperatures with exceptional plasticity of the weld deposit. Weldable with Mix gas.							
CLASSIFICATION	AWS	A 5.28: ER 120S-1						
	F-nr	6						
	FM	2						
SUITABLE FOR	Reh ≤ 960 MPa ISO 15608: ~3.1, 3.2 (Reh > 690 MPa) 1.8796, 1. 8925, 1.8940, 1.8983, 1.8797, 1.8933, 1.8934, 1.8941, 1.8997 S690Q-S890Q, S690QL-S890QL, S960Q, S960QL, S720MC ASTM A 709 Gr. 100 Type B, E, F, H, Q, HPS 100W N-A-XTRA M 620-700, PAS 700, alform 700 M, alform 900 x-treme, alform® 960 x-treme, Strenx 700-960, DILLIMAX 700-960							
APPROVALS	CE							
WELDING POSITIONS	      							
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S	Cr	Ni	Mo
	0.09	0.6	1.8	0.01	0.01	0.4	2.5	0.5
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness	
					-50°C			
	As Welded	800	880	19	80		HRc	
REDRYING	Not required							
GAS ACC. EN ISO 14175	M21, M13, M20							



CEWELD ER 120 S-1

ER 120 S-1 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417299

ER 120 S-1 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417305

ER 120 S-1 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417312

ER 120 S-1 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417329