



# CEWELD ER 120 S-1

**TYPE** Extreme high tensile strength alloy with excellent impact properties for fine grain steels exceeding 890 N/mm<sup>2</sup> yield strength.

**APPLICATIONS** Welding materials such as S960QL – S1100Q and other similar fine grain cold tough steels. Offshore, crane building etc.

**PROPERTIES** 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 Co<sub>2</sub> and Mix gas.

**CLASSIFICATION**

AWS	A 5.28: ER 120S-G
EN ISO	16834-A: G 89 5 M21 Mn4Ni2,5CrMo
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 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 (%)**

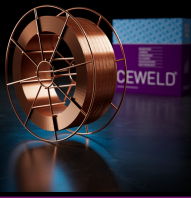
C	Si	Mn	P	S	Cr	Ni	Mo
0.11	0.6	1.8	0.01	0.01	0.4	2.4	0.4

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V	Hardness
				-50°C	
As Welded	960	1050	17	52	HRc

**REDRYING** Not required

**GAS ACC. EN ISO 14175** M21



# 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