

CEWELD ER 120 S-1

TYPE Extreme high tensile strength alloy with excellent impact properties for fine grain steels exceeding 890 N/mm² yield strength.

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

PROPRIÉTÉS 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 Co₂ 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 |

CONVIENT POUR **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

AGRÉMENTS CE

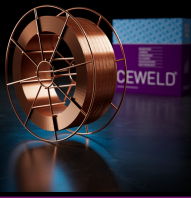
POSITIONS DE SOUDAGE

| 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 |

| PROPRIÉTÉS MÉCANIQUES | Heat Treatment | R _{P0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | Hardness |
|-----------------------|----------------|-------------------------|----------------------|--------------------|-------------------------|----------|
| | | | | | -50°C | |
| | As Welded | 960 | 1050 | 17 | 52 | HRc |

ETUVAGE Not required

GAS ACC. EN ISO 14175 M21



CEWELD ER 120 S-1

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|------------------|-----------|---------|---------------|
| 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 |