

# PRODUCT DATA SHEET

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Date: 8/26/2015  
Product: ER120S-1

**NAME OF PRODUCT** **ER120S-1**

**Classifications:** **AWS A5.28** **ER120S-1**

## TYPICAL MACHANICAL PROPERTIES

TENSILE ( N/mm <sup>2</sup> )	YIELD ( N/mm <sup>2</sup> )	Al% 5d	CVN + 20°C J	CVN - 50°C J			
980	900	19	160	100			

## CHEMICAL COMPOSITION ( average )

C %	Si %	Mn %	P %	S %	Cu %	Cr %	Ni %	Mo %	Al %	V %	Zr+Ti%			
0.08	0.55	1.75	<0.010	<0.010	<0.25	0.55	2.50	0.55	<0.10	<0.030	<0.15			

## WELDING PROCESS

Shielding Gas: MAG M21 ( 80%Ar + 20% CO<sub>2</sub> ) ; Argon ; CO<sub>2</sub> (C1)  
Pre Heating: 232°C  
Post Welding: as-welded

*Tollerance according to EN ISO 544*

## DIMENSIONS

MIG	0.035	0.045												
TIG	1/16	3/32	1/8											

## APPLICATION

Fine-grained middle alloyed steels with high yield strength and austempering steels

Lifting and handling machines, bridges, tanks, transport, shipbuilding, railway sector, mining industry, frames etc.