

TALARC 120

CLASSIFICATION

AWS SPECIFICATION	EN SPECIFICATION
AWSA5.28: ER120S-G	(EN ISO 16834-A: G89 4 Mn4Ni2CrMo)

ALLOY TYPE

Copper-coated solid wire for welding high strength steels.

APPLICATIONS

Low-alloy copper-coated solid wire with Ni-Cr-Mo additions, designed for welding high yield strength steels of 890 MPa and minimum tensile strength of 940 MPa. Excellent impact strength at low temperatures. Suitable for the metal working industry, offshore fabrication, chemical and petrochemical industry. It also has applications in fabrications of HSLA (high-strength low-alloy)steels, which may be used for industrial machinery construction, cranes and other highly stressed structural components. To be used under the shield of Ar+CO₂.

TYPICAL CHEMICAL COMPOSITION OF WIRE

C%	Mn%	Si%	S%	P%	Cr%	Ni%	Mo%	Cu%
0.08	1.80	0.80	0.007	0.007	0.40	2.20	0.50	0.10

TYPICAL MECHANICAL PROPERTIES

GAS		Yield strength	Tensile strength	Elongation on% 5d	Impact energy (Charpy V)				
		Rs	Rm	A5d	+ 20°C	0°C	-20°C	-40°C	-50°C
		(MPa)	(MPa)	%	(Joule)	(Joule)	(Joule)	(Joule)	(Joule)
MIX	As welded	890	940	16	140	100	90	90	-

WELDING GUIDELINES

Preheat and inter-pass temperature 150°C. PWHT is not required. To obtain the best mechanical properties results, low heat input is advised (follow the steel producer recommendations).

TECHNICAL INFORMATION

Gas: MixAr-CO₂(EN 14175)

Welding position: all positions



WELDING PARAMETERS

Current	DC+ Reverse polarity		
Diameter(mm)		1.2	
Volts(V)		18÷ 34	
Intensity(A)		100÷ 360	

Diam.	15kg Spool
1.2mm	INM120G1215

TALARC Pty Ltd
10-16 Syme St
Brunswick, Vic 3056
Ph. +61 3 9388 0588 Fax: +61 3 9388 0710
W: www.talarc.com.au E: sales@talarc.com