



# 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.

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

**CLASSIFICATION**

AWS	A 5.28: ER 120S-1
F-nr	6
FM	2

**CONVIENT POUR** **Reh ≤ 730 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, S690QLN-S890QLN  
 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, Strenx 700-890, DILLIMAX 700-890

**AGRÉMENTS** CE

**POSITIONS DE SOUDAGE**

ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)	C	Si	Mn	P	S	Cr	Ni	Mo
	0.09	0.6	1.8	0.01	0.01	0.4	2.5	0.5

PROPRIÉTÉS MÉCANIQUES	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	800	880	19	90	HRc

**ETUVAGE** 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