



WB120S-G M.I.G. WELDING WIRE

Classifications	AWS A5.28 : ER120S-G										
Product Description	Copper coated Chromium-Nickel-Molybdenum solid MIG wire.										
Applications	<p>WB120S-G is a solid MIG wire for the welding of high strength steels such as HY80, HY100 and other high yield alloy steels where the weld metal properties must match those of the parent material after normalising followed by quenching and tempering.</p> <p>The balanced Manganese and Silicon ensures optimum deoxidisation and weld fluidity.</p>										
Wire Composition(Weight %)		C	Mn	Si	S	P	Ni	Cr	Mo	Al	Cu (total)
min.		0.07	1.50	0.70	-	-	1.80	0.20	0.45	-	-
max.		0.12	2.00	1.00	0.020	0.020	2.30	0.40	0.65	0.03	0.30
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		950 min. typical 1101						
	Yield Stress/0.2% Proof Stress		N/mm ²		890 min. typical 960						
	Elongation on 5D		%		18 min. typical 20						
	Impact Energy CV @ -20°C		Joules		50 min. typical 89						
	Impact Energy CV @ -40°C		Joules		35 min. typical 78						
	Impact Energy CV @ -60°C as-welded		Joules		28 min. typical 75						

Wire Dia (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	80	120	160	180	-	-
	max.	-	180	240	260	300	-	-
Volt Range (Volts)	min.	-	17	17	18	20	-	-
	max.	-	20	22	26	29	-	-
Packaging Information								
Kg Per Reel		-	15	15	15	15	-	-
Storage	<p>Storage It is recommended that the WB range of wires are stored in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60%.</p>							
Gases	<p>Gas CO₂ and Argon/CO₂ mixture</p> <p>Flow Rate 12-16 l/min</p>							

Current Conditions DC+ and Welding Positions

