



WB120S-G MIG/MAG WELDING WIRE

Classifications	AWS A5.28: ER120S-G BS EN ISO 16834-A: G 89 4 M21 Mn4Ni2CrMo										
Product Description	Copper coated Chromium-Nickel-Molybdenum solid wire for MIG/MAG welding.										
Applications	<p>WB120S-G is a solid MAG 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 (Wt. %)											
	C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu (total)	
min.	0.07	1.60	0.60	-	-	1.80	0.20	0.45	-	-	
max.	0.12	2.10	0.90	0.018	0.015	2.30	0.45	0.75	0.03	0.30	
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength N/mm ² 940 min. Yield Stress/0.2% Proof Stress N/mm ² 890 min. Elongation on 5D % 15 min. Impact Energy CV @ -20°C Joules 47 min. Impact Energy CV @ -40°C Joules 47 min. As welded							Typical 1100 960 20 78 65			

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.	-	200	250	300	360	-	-
Volt Range (Volts)	min.	-	17	17	18	20	-	-
	max.	-	20	26	30	30	-	-
Packaging Information								
Kg Per Reel		-	15	15	15	15	-	-
Storage	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%.							
Gases	Gas CO ₂ and Argon/CO ₂ mixture Flow Rate 15-20 L/min							

Current Conditions DC+ and Welding Positions

