TECHNICAL DATA SHEET

parweld
WELDING THE FUTURE

XP 120

HIGH STRENGTH

CLASSIFICATIONS

EN ISO 16834-A	AWS A5.28
G 89 4 M21 Mn4Ni2, 5CrMo	ER120S-G

KEY FEATURES AND APPLICATIONS

- Low-alloyed solid wire designed for welding fine-grained, quenched and tempered high-strength steels.
- Provides a minimum yield strength of 890 MPa.
- High impact strength at low temperatures with exceptional plasticity of the weld deposit.
- Excellent mechanical properties at subfreezing temperatures down to -40°C.
- Widely used in the construction of high-strength pipelines, earthmoving and mining equipment, trucks, mobile cranes, concrete pumps and lifting equipment.

BASE MATERIALS

S890QL, S960Q; P460NH, P460NL1 ; Weldox 900, Weldox 960, Strenx 960

CHEMICAL COMPOSITION OF WIRE %

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu	V	Ti	Zr	Al
MIN	-	0.50	1.60	-	-	2.30	0.20	0.30	-	0.03	-	-	-
MAX	0.13	0.80	2.10	0.015	0.018	2.80	0.60	0.65	0.30	0.13	0.10	0.10	0.12

Single values are maximum values according to EN ISO 16834

MECHANICAL PROPERTIES OF ALL-WELD METAL - TYPICAL (MIN.) VALUES

Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Impact ISO-V (J)	Test Temperature
960 (≥890)	1040 (940 - 1180)	16 (≥15)	60 (≥47)	-40°C

Test data for mechanical properties are not guaranteed since actual as welded conditions depend on numerous variables

OPERATING DATA

Shielding Gases	Polarity
EN ISO 14175 - M21	DC+

PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Spool	Weight (kg)	Pallet Qty
XP15272	0.8	BS300	15	72
XP15275	1.0	BS300	15	72
XP15278	1.2	BS300	15	72

MADE IN EU