TECHNICAL DATA SHEET

parweld
WELDING THE FUTURE

XP 120

HIGH STRENGTH

CLASSIFICATIONS

EN ISO 16834-A	AWS A5.28
W 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		
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 - I1	DC-

PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Length (mm)	Weight (kg)	Packaging
XP15366	1.6	1000	5	PAP 20 Tube
XP15368	2.4	1000	5	PAP 20 Tube
XP15370	3.2	1000	5	PAP 20 Tube

MADE IN EU