BÖHLER alform® 1100-IG

Solid Wire, low-alloyed, high strength

Classifications

EN ISO 16834-A -	AWS A5.28 / SFA-5.28
G 89 5 M Mn4Ni2,5CrMo	ER120S-G

Characteristics and typical fields of application

High-strength, medium alloy solid wire electrode for shielded arc welding of quenched and tempered fine grained structural steels. Optimized and tested welding results with the steel alform® 1100 x-treme. Outstanding tough weld metal at low temperature. Good resistance to cold cracking due to high purity of the wire surface. For use in crane and vehicle manufacturing.

Base materials

alform® 1100 x-treme

Typical analysis

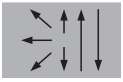
	C	Si	Mn	Cr	Ni	Mo
wt.-%	0.12	0.8	1.9	0.45	2.35	0.55

Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A (L_0=5d_0)	Impact energy ISO-V KV J	
	MPa	MPa	%	20°C	-50°C
u	≥930	≥980	≥14	-	≥47

u untreated, as welded – shielding gas Ar + 15 – 25% CO_2

Operating data



Polarity	DC+
Shielding gas (EN ISO 14175)	Ar + 15 – 25% CO_2

Dimension mm
1.0
1.2

Preheating and interpass temperature as required by the base metal.

Approvals

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