Union X 96

Solid Wire, low-alloyed, high strength

Classifications

EN ISO 16834-A	AWS A5.28 / SFA-5.28
G 89 5 M21 Mn4Ni2,5CrMo	ER120S-G

Characteristics and typical fields of application

GMAW low-alloyed solid wire electrode for joining of quenched and tempered and thermomechanically rolled fine-grained structural steels in crane and vehicle constructions. Good deformability in spite of very high strength values. Good resistance to cold cracking.

Base materials

S960Q, S960QL;
S890Q, S890QL;
S890MC;
S960MC

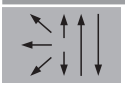
Typical analysis

	C	Si	Mn	Cr	Ni	Mo
wt.-%	0.12	0.82	1.90	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		Shielding gas
	MPa	MPa	%	20°C	-50°C	
u	930	980	14	80	47	M21
u untreated, as welded						

Operating data



Polarity	DC+
Shielding gas (EN ISO 14175)	M20 M21

Dimension mm
0.8
1.0
1.2

Approvals

DB (42.132.26), CE