MIGWELD 890

MIG/MAG Wires [GMAW]

Low alloyed steel

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 16834-A : G 89 6 M21 Mn4Ni2CrMo AWS A-5.28 : ER 120S-G		Constructions & Engineering Mining

- Solid copper coated welding wire with Mn, Ni and Cr for welding in gas shielding atmospheres.
- Recommended for high tensile finegrained steels with yield strength up to 890 N/mm^2.

Base material

High tensile finegrained steels:	S890QL
	XABO 890
	MICRAL 890

Typical chemical composition %

C	Si	Mn	Cr	Ni	Mo
0,09	0,80	1,80	0,36	2,23	0,55

Typical mechanical properties

Yield strength Re [N/mm2]	>890
Tensile strength Rm [N/mm2]	940-1180
Elongation A5 [%]	15
Impact energy Kv [J]	>47J (-60°C) /
Wire/rod type	solid
Welding current	
Welding positions	
Shielding gases acc. to EN ISO 14175	M21 - Ar + 15 - 25% CO2 /

Welding parameters and packing

⌀	Welding current [A]	Voltage [V]	Weight of packet [kg]
1,0	80-95	17-19 short arc	15,0
1,0	240-270	24-27 spray arc	15,0
1,2	110-130	18-20 short arc	15,0
1,2	270-320	27-32 spray arc	15,0

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