

MIGWELD 960

MIG/MAG Wires [GMAW]

Construction, unalloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 16834-A : G 89 5 M21 Mn4Ni2,5CrMo AWS A-5.28 : ER 120S-G		Steel construction yards Mining Automobile

- Welding wire for welding high strength fine grain steels.

Application

Cranes, concrete pumps and booms, automotive industry

Base material

	EN	DIN	
Finegrained steels	S420N, S500N, S420NL, P420NH-P500NH, S690QL, S690Q, L690M	StE 420-StE500, TStE420, WStE420-WStE500, TStE690V, StE690.7	
Heat treated finegrained steels	S550QL1, S620QL1, S690QL1	N-A-XTRA56, N-A-XTRA63, N-A-XTRA70, T1, T1A, T1B, HSB77V, Weldox 700, BH70V Hy90, Hy100, Welten 80, Bisalloy 80	
Pipes	L485MB, L555MB	X60, X65, X70, X80	

Typical chemical composition %

C	Si	Mn	Cr	Ni	Mo
0,10	0,80	1,90	0,45	2,35	0,60

Typical mechanical properties

Yield strength Re [N/mm2]	890
Tensile strength Rm [N/mm2]	940-1180
Elongation A5 [%]	15
Impact energy Kv [J]	>47 J (-50°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

Ø	Welding current [A]	Voltage [V]	Weight of packet [kg]
1,2	110-130	18-20	15,0