

<u>Specifications:</u>	<u>Welding Parameters:</u>	<u>Properties:</u>
AWS A5.28/ASME SFA 5.28 AWS Class ER120S-G EN 12534 G84MMn4Ni2CrMo	Spray transfer: .035": 160-200 AMPS; 28-32 Volts; 98 Ar/2 O ² .045": 180-220 AMPS; 30-34 Volts; 75 Ar/25 CO ² Short Arc: .035": 100-140 AMPS, 22-25 Volts, 100% CO ² .045": 120-150 AMPS, 23-26 Volts, 75 Ar/25CO ²	Tensile Strength: 137,785 PSI Yield Strength: 129,080 PSI Elongation: 16% CHARPY V NOTCH @ - 40°F: 66 Joules

Description:

WT 120S-1 is a low alloy welding wire used in MIG and TIG welding. It has a high strength and low temperature toughness. It has a good resistance to cold cracking and is often used for joining large manufacturing as well as high strength pressure vessels.

Available in multiple sizes and forms.

Chemical Composition (Wt%)

C	Mn	Si	P	S	Ni	Cr	Mo	V	Ti	Zr	Al	Cu
.09	1.9	0.80	.005	0.005	2.15	0.35	0.55	0.004	0.08	0.012	0.01	0.13

Note: Single values are maximum unless otherwise noted.

Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of material being welded.

CAUTION: Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33126: OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.