

CARBOFIL 120

MIG-MAG Wires High strength steels

Carbofil 120 is a copper coated solid wire suitable for welding Cr-Ni-Mo low alloyed and high yield strength steels. Excellent mechanical properties, yield strength 890 N/mm² and tensile strength = 920 N/mm².

Classification

AWS	A5.28: ER 120S-G
EN	12534: G 89 4 M Mn4Ni2CrMo

Approvals

Grades

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.07	1.60	0.75	≤ 0.015	≤ 0.018	0.30	2	0.60	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) -40°C	Hardness
As Welded	≥ 890	≥ 920	≥ 16	≥ 47	-

Gas test: Acc. To EN 439: M21(Arcal 21-Atal 6)

Shielding Gas: Acc. To EN 439: M21(Arcal 21-Atal 6)

Materials

S690; S890

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data: K300 Kg. 16

Diameters	1,0	1,2			
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