



## SELECTARC MIG F79

Old reference : MIG 120 S1

### Classification

AWS A5.28 : ER120S-G

ISO 16834-A

: G Mn4Ni2CrMo

### Characteristics

Copper coated filler wire for gas shielded welding of low alloy, high strength and high elastic limit (Re>900MPa) steel.

### Applications

For welding of high strength steel

#### Base Materials

EN	Material N°
S890Q	1.8940
S890QL	1.8928
S890QL1	1.8925
S960Q	1.8941
S960QL	1.8933

### Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	S	P	Fe
0.09	0.70	1.90	0.30	2.20	0.50	0.015	0.014	base

### All Weld Metal Mechanical Properties (Typical)

Conditions	UTS	YS	% Elg	Impact (KV)	
	R <sub>m</sub> (MPa)	R <sub>p0.2</sub> (MPa)		Temp. °C	J
AW	950	860	16	- 20	140
				- 40	90
				- 50	70

### Welding Current & Instructions

Welding Mode	Wire Ø ( mm )	Welding Mode		Shielding Gas ISO 14175
		(A)	(V)	
MIG = +	1.0	150 - 170	25 - 28	M21 (Ar/CO <sub>2</sub> ) C1 (100% CO <sub>2</sub> ) 12-15 l/min
	1.2	180 - 250	26 - 28	

**Liability:** This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.