

## MIGWELD 890

MIG/MAG Wires [GMAW]

Low alloyed steel

|   |                   |  |
|---|-------------------|--|
| <b>CLASSIFICATION:</b><br>EN ISO 16834-A : G 89 6 M21<br>Mn4Ni2CrMo<br>AWS A-5.28 : ER 120S-G | <b>APPROVALS:</b> | <b>APPLICATION:</b><br>Constructions & Engineering<br>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<sup>2</sup>.



### Base material

|                                  |            |
|----------------------------------|------------|
| High tensile finegrained steels: | S890QL     |
|                                  | XABO 890   |
|                                  | MICRAL 890 |

### Typical chemical composition %

|          |           |           |           |           |           |
|----------|-----------|-----------|-----------|-----------|-----------|
| <b>C</b> | <b>Si</b> | <b>Mn</b> | <b>Cr</b> | <b>Ni</b> | <b>Mo</b> |
| 0,09     | 0,80      | 1,80      | 0,36      | 2,23      | 0,55      |

### Typical mechanical properties

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