



ED FK1000-S1

Manufactured by **FLIESS-GERMANY**

GMAW Wires for High Strength Steel (X 90) – **AWS A5.28/ASME SFA-A5.28 ER120S-G**

Key Characteristics

- Wire for welding high strength low alloy steel
- Wire for welding high strength steel in many high stress critical applications
- Excellent toughness down to -60°C

Base Material

High strength fine grained structural steel up to yield strength 890 MPa (129Ksi)

HY80, HY100 steels

Typical Applications

- Mining, Shipbuilding, concrete pump, automotive
- Crane manufacturing, pressure vessels

Typical Analysis %

Typical Wire Composition	%C 0.09	%Mn 1.8	%Si 0.80	%S 0.010	%P 0.007
Typical Wire Composition	%Cr 0.30	%Ni 2.25	%Mo 0.55	%Cu 0.014	%Ti 0.05

Mechanical Properties

	Y.S. MPa (ksi)	T.S MPa (ksi)	Elongation %	Impact Energy J
Typical Results (all weld metal) As welded	890 mpa	940 mpa	4d/5d 17	-60C 47 J

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Ordering Information

Product Number	Product (AWS Specification)	Dimension mm/inches	Single Tube Weight kg/lb	Box Weight kg/lb
453090115	ED FK1000-S1 (ER120S-G)	0.90 mm (0.035")	15.0 kg (33.0 lb)	15.0 kg (33.0 lb)
453120115	ED FK1000-S1 (ER120S-G)	1.2 mm (0.045")	15.0 kg (33.0 lb)	15.0 kg (33.0 lb)

