

MG 192

Gas Metal Arc (MAG) Welding Wire - High Strength and Low Alloyed Steels

Standards	
AWS/ASME SFA - 5.28	ER120S-G
EN ISO 16834 - A	G 89 6 M21 Mn4Ni2CrMo
TS EN ISO 16834 - A	G 89 6 M21 Mn4Ni2CrMo

Properties and Applications

Low alloyed wire electrode for GMA (MIG/MAG) welding of fine grained and high strength steels with yield strength of up to 960 N/mm². Weld metal exhibits good toughness properties down to -60°C. Especially used in earthmoving, mining equipments, trucks, mobile cranes, concrete pumps crane, lift and oilfield equipments productions.

Materials	
Width	ASTM
S690Q-S890Q	
S690QL-S890QL	
S690QLN-S890QLN	
*S960QL	
*S1100QL	
*S1300QL	
	HY80
	HY100
	Q1(N)
	Q2(N)

Typical Chemical Features of the Welding Wire						
Type of Analysis	C	Si	Mn	Cr	Ni	Mo
Welding Wire	0.09	0.80	1.80	0.30	2.20	0.55

Typical Mechanical Values of Weld Metal					
Test Condition	Protection Gas	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	M21	980	1050	15	-60°C → 50

* Chemical composition and mechanical properties are valid when using shielding gas .

Application Information

Welding Positions

PA PB PC PD PE PF PG

Polarity:

Protection Gas:
M21

Welding Parameters & Efficiency

Diameter (mm)
1.00
1.20

Packaging Information						
Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
22025DJAM2	1.00	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
22025EJAM2	1.20	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)

Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.