

ESAB 120



A low hydrogen, low alloy electrode for welding low alloy, high strength structural steels



Classification AWS A5.5: E 12018-M
 IS 1395: E83 BM 426Fe

DESCRIPTION

ESAB 120 is all position low hydrogen electrode designed to give a tough weldmetal avoiding risk of temper brittleness. The excellent operation in all positions with smooth arc, very little spatter, easily detachable slag, a final weld appearance that is smooth and fine rippled makes ESAB 120, highly popular among welders. The final weldmetal possess very low level of hydrogen (less than 2ml/100g of weldmetal) and is radiographically sound.

WELDING CURRENT: DC, AC 70V

TYPICAL APPLICATIONS

Used for steels with a yield point of upto 740 N/mm². The electrode is intended for welding low alloy high strength structural steel including quenched and tempered steels such as HY 80, N-A-XTRA70, USS T1 grades etc. Used for components of penstock, earth moving equipment and other steel fabrications made of high tensile steels.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.06	S	0.018	YS	790 N/mm ²
Mn	2.00	Ni	2.20	UTS	860 N/mm ²
Si	0.50	Cr	1.00	EL (L=5d)	22%
Mo	0.45	V	0.05	Impact (CVN) at -51°C	60J
P	0.018				

Diffusible Hydrogen = 1.9ml/100gm of weldmetal

APPLICATIONS

ESAB 120 is meant for the welding of very high tensiles.

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
3.15	450	90-125	90	360
4.00	450	120-180	60	240
5.00	450	160-240	40	160

PACKING: Electrodes are packed in cartons and four of these cartons are shrink-wrapped in a cardboard box.