

SPOOLARC 120 AWS /ASME SFA 5.28: ER120S-1

FEATURES

Spoolarc 120 is designed for welding high strength quenched and tempered steels. Weld metal mechanical properties produce high tensile strengths, in excess of 120 ksi (825 MPa). Applications for Spoolarc 120 include military tanks, ships, submarines and other similar fabrication.

CLASSIFICATIONS AND APPROVALS

- AWS/ASME SFA 5.28: ER120S-1
- AWS/ASME SFA 5.23 EM4

WELDING PROCESS

- GTAW (TIG)

INDUSTRIES

- Mobile Machinery
- General Fabrication
- Shipbuilding

TYPICAL MECHANICAL PROPERTIES

As Welded GMAW 98% Ar / 2% O ₂	
Yield Strength	112 ksi, 775 MPa
Tensile Strength	123 ksi, 840 MPa
Elongation in 2"	19%

CHARPY V-NOTCH PROPERTIES

Testing Temperature -60°F (-51°C)	
As Welded GMAW 98% Ar / 2% O ₂	
75 ft-lb, 102 J	
Testing Temperature 0°F (-18°C)	
As Welded GMAW 98% Ar / 2% O ₂	
100 ft-lb, 136 J	

WELD METAL ANALYSIS

GMAW 98% Ar / 2% O ₂	
C	0.07%
Mn	1.3%
Si	0.35%
P	0.007%
S	0.008%
Cr	0.4%
Ni	2.6%
Mo	0.45%
Typical Wire Analysis	
C	0.05%
Mn	1.6%
Si	0.3%
P	0.005%
S	0.004%
Cr	0.3%
Ni	2.3%
Mo	0.5%

SPOOLARC 120

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PART NUMBER / PRODUCT INFORMATION		
Part Number	Description	UPC
2117F08	120 CU 1/16X36X25#CT F1	662303669058
2117F10	120 CU 3/32X36X30#CT F1	662303669041
2117F12	120 CU 1/8X36X40#CT F1	662303670436