

TECHNIWELDUSA

| | | | | |
|-----------------|-----------------|-----------------|-----------------|-----------------|
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TYPICAL MATERIAL TEST REPORT

| ITEM CLASSIFICATION | |
|---|---------------|
| ALLOY | SPECIFICATION |
| ER120S-1 | AWS A5.28 |
| APPLICATIONS | |
| Used for a variety of steels where high strength and ductility are cr4itical. | |

| TYPICAL CHEMICAL COMPOSITION | | | | | | |
|------------------------------|---------|------|-----------|-----------|-------|--|
| | ELEMENT | C | Mn | Si | P | |
| | AVERAGE | 0.10 | 1.40-1.80 | 0.25-0.60 | 0.010 | |

| | ELEMENT | S | Ni | Mo | Cr | |
|--|---------|-------|-----------|-----------|------|--|
| | AVERAGE | 0.010 | 2.00-2.80 | 0.30-0.65 | 0.60 | |

| TYPICAL MECHANICAL PROPERTIES | | | | |
|-------------------------------|------------------|----------------|------------|--|
| | Tensile Strength | Yield strength | Elongation | |
| | (N/mm2) | (N/mm2) | % | |
| | 120,000 psi | 105,000 psi | 14% | |

| WELDING PROCESS | | |
|-----------------|-------------|-------|
| | Pre Heating | 300°F |