

## IABCO FK1000 MIG

### MIG/GMAW wire for low alloy high strength steels

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| Product name   | IABCO FK1000 MIG   |
| Classification EN ISO                                | 16834-A: G Mn4Ni2CrMo<br>G 89 6 M21 Mn4Ni2CrMo   |
| Material No.   | -  |
| Classification AWS                                   | A5.28: ER120S-G  |
| Approvals  | TÜV 12690.00, CE.  |
| Applications   | MIG/GMAW wire for welding high strength low alloy steels. Used for welding high strength steels in many high stress, critical applications; also exhibiting excellent toughness down to -60°C. Typical applications can be found in the mining, shipbuilding, automotive and pressure vessel industries. |
| Base materials                                       | For high strength fine-grained structural steels up to yield strength 890MPa (129ksi).<br>HY80, Q1(N), HY100, Q2(N)<br>S690Q-S890Q, S690QL-S890QL, S690QLN-S890QLN.  |
| Typical analysis of wire, weight %                   | C: 0.09<br>Si: 0.80<br>Mn: 1.80<br>Cr: 0.31<br>Ni: 2.20<br>Mo: 0.55  |
| Typical heat treatment <sup>(1)</sup>                | Welding procedure, including preheat temperature, interpass temperature and PWHT, will be dependent on the base material being welded and any applicable design codes.   |
| Mechanical properties of weld deposit <sup>(2)</sup> | M21 shielding gas: 0.2% proof stress Rp0.2%: ≥890MPa.<br>Tensile strength Rm: ≥940MPa.<br>Elongation 4d/5d: ≥15%.<br>Impact ISO-V, -60°C: ≥47J.  |
| Other products                                       | -  |

**Notes** (1) Application codes and project specifications should always be referred to for specific requirements.

(2) Actual mechanical properties will be dependent on specific welding procedure (including shielding gas, flux, PWHT etc) and should always be confirmed by approval of an appropriate welding procedure.