

TECHNICAL DATA

Standards

DIN Material Nr. 1.8988

EN ISO 16834-A :	G 89 4 M21 / Mn4Ni2CrMo
AWS A5.28 :	ER120S-G

General Properties / Field of Applications

DSI M 95Plus is a high-strength low-alloyed (HSLA) Laser Welding Wire for supreme performance in etching surfacing process, mirror surface finishing. Designed to reduce micro porosity, high cleaned material. Applicable for carburising and nitride coating. For welding of high-strength, quenched and tempered fine-grained structural steels. Weld metal for operating temperatures from -40 to 450°C.

Mechanical Properties

Yield strength $R_{p0.2}$	[MPa] / [N/mm ²]	900
Tensile strength R_m	[MPa] / [N/mm ²]	960
Hardness	[HRC]	30 - 38
Elongation A ($L_0 = 5d_0$)	[%]	17

Chemical Composition (Standard Values in %)

C	Si	Mn	Ni	Cr	Mo
0.1	0.7	1.8	2.0	0.4	0.5

Compatible Materials (Selection)

S500ML / S690Q-S890Q / S690QL-S890QL / S960Q / S960QL / HPS 100W
ASTM A 709 Gr. 100 Type B, E, F, H, Q / S460Q / S460QL / S460QL1

Packaging and available Sizes*

Spool : MA125 mm	Ø mm	0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2
Rod : 500 / 1000 mm	Ø mm	0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2

* Other dimensions available on request

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