



Quality Management System
in accordance with
ISO 9001
Cert # 05-R0925

980X

Low Alloy High Strength Alloy Steel

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com



ALLOY DESCRIPTION AND APPLICATION;

980X is commonly a copper coated high strength alloy steel that contains high levels of nickel, manganese, silicon and molybdenum for stronger toughness and excellent welding results on fine grained high stress critical applications. Commonly found on Automotive, cranes, ships, mining, concrete pressure vessel and many other quenched and tempered steels. Used on base metals S690Q/QL/LN, S890Q/QL/LN, S906QL, S110QL, S1300QL
Excellent replacement for the Bosch DS980J which is no longer available

TYPICAL GMAW WELDING PROCEDURES; DCEP Short Circuit 75-80Ar/20-25CO₂

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Travel speed (ipm)	(cfh)
0.030	110-340	140-230	25-32	12-24	20-35
<i>*Thin gauge setting</i>	80-220	50-180	18-22	8-20	20-30

*Consult your recommendations found in repair manuals as needed for complete repairs

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

TYPICAL WIRE CHEMISTRY (%) AND WELD METAL PROPERTIES;

	980X		980X
Carbon	0.09	Tensile Strength (psi)	150,800 min.
Manganese	1.80	Yield Strength (psi)	139,400 min.
Silicon	0.80	Elongation in 2"	15%
Nickel	2.25	Charpy V-notch at -76°F	47 ft·lbs
Molybdenum	0.55	70°F	75 ft·lbs
Chromium	0.30		
Copper contents and coating 0.5 max.			

AVAILABLE SIZES: TC EAGLE-ARC 980X = Spools of .030

SPECIFICATIONS; AWS A5.28 ER120S-G
DIN EN ISO 16834-A , G 89 6 M21 Mn4Ni2CrMo

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