



# AUTOMIG 90S-D2

GMAW LOW ALLOY STEEL (High Strength)

AWS A/SFA 5.28 **ER90S-D2**

## KEY FEATURES:

- Copper coated solid filler wire and rod
- Mn-0.5 Mo type welds deposit
- Uniform copper coating
- Mo addition for high strength
- High level of deoxidizers for defect free welds
- Excellent low temperature toughness
- Porosity free radiographic quality weld

## APPROVALS: IBR

## TYPICAL APPLICATIONS:

- Welding of high tensile steels like IS 8500 Gr.540B,570B & 590B, IS 2002 Gr.3, IS 1875 Class 3A
- Welding of Sailma 450/450HI steel used in CONCOR wagon
- Suitable for single and multiple pass welding
- High temperature service pipe, fittings, flanges and valves


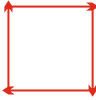
## TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Si	Mo
0.09	1.7	0.5	0.45

## MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -30°C, J
Typical	As Welded	640	580	20	50 min

## PARAMETERS - PACKING DATA:

<b>∅, mm</b> 1.2 1.6	<b>Kg/Spool</b> 15 15	 <b>DCEP</b>  <b>STORAGE / HANDLING :</b> Keep dry and follow handling instructions mentioned on the box	<b>All Positions</b> 
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<b>Shielding Gas</b> Ar/1-5O <sub>2</sub>	<b>Gas Flow Rate, LPM</b> 15-22
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