



AUTOMIG 90S-G

GMAW LOW ALLOY STEEL (High Strength)

AWS A/SFA 5.28 ER90S-G

KEY FEATURES:

- Copper coated high strength low alloy steel GMAW wire & rod
- Welds even over poor cleaned base metals
- Moderately high strength with adequate low temperature toughness
- Exhibits excellent out of position characteristics
- Radiographic weld quality

TYPICAL APPLICATIONS:

- Welding high sulfur bearing free machining steels, medium carbon steels, 0.5 Mo steels and high temperature resistant steels
- Pipelines and pressure vessels with operating temperatures of about 500°C
- Repair of medium strength steel castings



TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Si	Mo
0.09	1.7	0.55	0.5

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	650	570	25	45

PARAMETERS - PACKING DATA:

Ø, mm	Kg/Spool		
1.2	15	 DCEP	All Positions 
1.6	15		

STORAGE / HANDLING :
Keep dry and follow handling instructions mentioned on the box

Shielding Gas	Gas Flow Rate, LPM
Ar/1-5O ₂	15-20