



TIGFIL 90S-G

GTAW 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


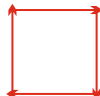
TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

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 x L, mm	Net Wt., Kg		
1.6 x 1000	20	 DCEN STORAGE / HANDLING : Keep dry and follow handling instructions mentioned on the box	All Positions 
2.0 x 1000	20		
2.4 x 1000	20		

Shielding Gas	Gas Flow Rate, LPM
Ar	10-15

Available in Standard carton packing of 20 kg box, containing 4 plastic tubes of 5 kg each.