

## ❖ Product Description

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|--|---|
| I. Copper coated solid wire                  | V. Deoxidizers added for defect free welding      |
| II. Uniform copper coating                   | VI. Toughness increases at low temperature        |
| III. Mn-0.5Mo type weld deposits             | VII. Radiographic weld quality free from porosity |
| IV. Strength is increased due presence of Mo |   |

## ❖ Range of Application

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|--|---|
| I. For welding high tensile steels like IS8500 Gr.504B & 590B, IS 2002 | III. Highly suitable for welding variety of low alloy, higher strength steels |
| II. Suitable for a single and multipass welding                        |   |

## ❖ Classification

- AWS/SFA 5.28 ER90S- D2

## ❖ % Chemical Composition

Type of Wire		C	Mn	S	Si	Ni	Mo	P	Cu	Other Elements
ER90S- D2	Min	0.07	1.60	-	0.50	-	0.40	-	-	-
	Max	0.12	2.10	0.025	0.80	0.15	0.60	0.025	0.50	0.50

## ❖ Mechanical Properties of all weld metal

Condition	UTS, Mpa (Min)	YS, MPa (Min)	% Elongation	Charphy "v" Notch Impact @ - 30°C
As Welded	620	540	17	27J

## ❖ Wire Size & Welding Position

- Diameter in mm- 0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60
- Weld Position- All position

## ❖ Current & Gas Flow

- DCEP; 15-22lit/min

## ❖ Packaging

Sizes Available in mm	0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60								
Packing Code	A	B	C	D	E	F	G	H	I
Packing Available	SD 100	SD200	SD270	SD 270	SD300	SD300	100kg Drum Pack	250kg Drum Pack	350kg Drum Pack
Net Weight of Wire	1KG	2KG	12.5KG	15KG	12.5KG	15KG	100KG	250KG	350KG

### Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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