

❖ Product Description

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| I. Copper coated, high strength low alloy steel wire | IV. Sufficiently high strength with sufficient low temperature toughness |
| II. Uniform copper coating | V. Radiographic weld quality free from porosity |
| III. Capable of welding poor base metals with presence of impurities | |

❖ Range of Application

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| I. For welding high sulphur bearing free machining steels, medium carbon steels, 0.5 Mo steels and high temperature resistant steels | II. Suitable for a single and multipass welding |
| | III. Pipelines, pressure vessels with operating temperatures of about 500°C |

❖ Classification

- AWS/SFA 5.28 ER90S-G

❖ % Chemical Composition

Type of Wire		C	Mn	S	Si	Ni	Mo	P	Cu	Other Elements
ER90S- G	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	Charpy "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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