

❖ Product Description

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|---|---|
| I. Copper coated high in strength low alloy steel wire | III. Uniform and shiny weld beads formation |
| II. The weld deposition rate is high, it gives smooth wire flow | IV. Radiographic weld quality |

❖ Range of Application

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|---|---|
| I. For welding pipe lines and pressure vessels operating at high temperatures | III. For pipelines and pressure vessels which operate at nearly 500°C |
| II. For repairing medium strength steel castings | |

❖ Classification

- AWS/SFA 5.28 ER90S-G

❖ Chemical Composition

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

❖ Mechanical Properties of all weld metal

Condition	UTS, Mpa (Min)	YS, Mpa (Min)	% Elongation	Charpy "v" Notch Impact @ 0°C
As Welded	620	540	17	27J

❖ Wire Size & Weld Position

- Diameter in mm-1.6, 2.0 2.40,3.20,4.00 and 5.00.
- All position

❖ Current and Gas- Flow Rate

- DCEN & 8-15 lit/min

❖ Packaging

Sizes available in cut length of 1000mm	1.60,2.00,2.40,3.20,4.00,5.00			
Packing Code	A		B	
Packing Available	5kg PLASTIC TUBE	20KG BOX	10KG PAPER TUBE	20KG BOX
Net Weight of Wire	5	20	10	20

Special Note: -

All the value above mentioned are typical values.

- (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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