

SUNMIG 90S-D2

Copper Coated Low Alloy Wire for Mn-Mo Steel Welding



CLASSIFICATION

AWS A 5.28 : ER90S-D2

CHARACTERISTICS

SUNMIG 90S-D2 contains 0.5% Mo to provide higher deposit strength in both the as welded and stress relieved conditions. It has high level of deoxidizers for defect free welds and possesses excellent low temperature toughness.

APPLICATIONS

SUNMIG 90S-D2 is suitable for pipelines, fittings, flanges, valves and pressure vessels with operating temperatures of about 500°C. Application in welding of high tensile steels like IS 8500Gr.540B, 570B & 590B, IS 1875 Class 3A and also for welding of Sailma450/450Hi steel used in CONCOR wagons.

CHEMICAL COMPOSITION OF BARE SOLID WIRE (TYPICAL) (%):

Carbon	Manganese	Silicon	Molybdenum	Copper*	Sulphur	Phosphorus
0.07-0.12	1.60-2.10	0.50-0.80	0.40-0.60	0.50 max	0.025 max	0.025 max

*Including Cu in the coating

SPECIFIED MECHANICAL PROPERTIES OF ALL WELD METAL:

Condition	Ultimate Tensile Strength	Yield Strength	Elongation	CVN Impact at -30°C
As welded	620 N/mm ² min	540 N/mm ² min	17% min	30 Joules min

PACKING DATA:

Diameter (mm)	KG/spool
1.20	15 Kg
1.60	15 Kg

SHIELDING GAS :

95-98% Argon / Balance O₂