



AUTOMIG IV

GMAW LOW ALLOY STEEL (High Strength)

AWS A/SFA 5.28 **ER90S-D2**

KEY FEATURES:

- Copper coated solid filler wire and rod
- Mn-0.5 Mo type welds deposit
- Uniform copper coating
- Mo addition for high strength
- High level of deoxidizers for defect free welds
- Excellent low temperature toughness
- Porosity free radiographic quality weld

APPROVALS: IBR/RDSO

TYPICAL APPLICATIONS:

- Welding of high tensile steels like IS 8500 Gr.540B,570B & 590B, IS 2002 Gr.3, IS 1875 Class 3A
- Welding of Sailma 450/450Hi steel used in CONCOR wagon
- Suitable for single and multiple pass welding
- High temperature service pipe, fittings, flanges and valves



TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Si	Mo
0.09	1.7	0.5	0.45

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	640	580	20	50 min

PARAMETERS - PACKING DATA:

Ø, mm	Kg/Spool		
1.2	15	 DCEP STORAGE / HANDLING : Keep dry and follow handling instructions mentioned on the box	All Positions 
1.6	15		

Shielding Gas	Gas Flow Rate, LPM
Ar/1-5O ₂	15-22