

GETIG 90S-D2

IDENTIFICATION

Getig 90SD2, ER 90SD2

CLASSIFICATION

AWS/SFA 5.28: ER 90S-D2

DESCRIPTION

Copper coated solid wires alloyed with manganese & molybdenum for improved properties. Deposited weld metal has excellent creep resistance properties up to 500°C.

CHEMICAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Ni	Mo	Cu
0.07 - 0.12	1.60 - 2.10	0.5 - 0.80	0.025 max	0.025 max	0.15 max	0.40 - 0.60	0.35 max

MECHANICAL PROPERTIES (RANGE) (PWHT 620 ±150C/2 HRS.)

UTS (MPa)	YS (MPa)	EL (%) (L=4D)
630 min	550 min	17 min

TYPICAL APPLICATIONS

- In general usable on the following grades of creep resistant steels.
- DIN 15 Mo3, GS-22Mo4, 19Mn6, ASTM A3 36 Gr F1, ASTM A 335Gr P1, ASTM A185 Gr F1 etc.
- For welding AISI 4130 steel / forgings.

SHIELDING GAS : 99.99 % Argon, 7-12 l/min, and back purge **PREHEAT AND INTERPASS**

TEMPERATURE : 135 - 165°C **WELDING CURRENT** : DC (-)

PWHT :

The PWHT requirements will depend on a number of factors including, base material, property requirements, and need to conform to NACE etc. Temperatures will normally be about 620°C.

PACKING PARAMETERS

Size (mm)	Length (mm)	Packing / Pkt (kg)	Packing / Box (kg)
1.6	1000	5	5 X 4 = 20
2	1000	5	5 X 4 = 20
2.40 / 2.50	1000	5	5 X 4 = 20
3.15 / 3.20	1000	5	5 X 4 = 20