

# GM 90S-D2

## IDENTIFICATION

GM 90S-D2, ER 90SD2

## CLASSIFICATION

AWS/SFA 5.28 ER 90S-D2

## DESCRIPTION

GM 90SD2 is a solid wire for flat and horizontal fillet welding position. As the deposition rate very high, highly efficient welding can be performed. Deposited weld arc of radiographic quality.

## CHEMICAL ANALYSIS (RANGE) %

C	Si	Mn	P	S	Mo
0.07 - 0.12	0.5 - 0.8	1.60 - 2.10	0.025 max	0.025 max	0.40 - 0.60 max

## MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	EL (%) (L=5D)	CVN Impact Value	
			Temp	Joules
620 min	540 min	24 min	-20°C	120

## TYPICAL APPLICATIONS

- For welding of steel to IS 8500-91 Grade 540B, 570B and 590B Butt and fillet welding of steel structures construction machinery, building and pressure vessels.
- IS 2002-92 Grade III and
- IS 1875-92 Class III A

**WELDING CURRENT : DC (+)**

**SHIELDING GAS : CO2 PACKING PARAMETERS**

## PACKING PARAMETERS

Size (mm)	Weight / Spool (kg)
0.8	12.5 / 15.0
1.2	12.5 / 15.0
1.6	12.5 / 15.0