

GM 90SG

IDENTIFICATION

GM 90SG, ER90SG

CLASSIFICATION

AWS/SFA 5.28: ER90S-G

DESCRIPTION

A solid alloyed wire specially developed for flat and horizontal fillet and butt welding position. The deposited weld metal has uniform weld bead shape.

CHEMICAL ANALYSIS (RANGE) %

C	Si	Mn	P	S	Mo	Cu
0.10 max	0.4 - 0.75	1.20 - 1.60	0.020 max	0.025 max	0.2 - 0.40	0.30 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	PS (MPa)	EL (%) (L=49)	CVN Impact Value	
			Temp	Joules
625 - 725	550 - 650	22 -30	-20°C	80 -150

TYPICAL APPLICATIONS

- For welding of high tensile steels of having UTS of 550 MPa and 620 MPa etc.
- For fabrication of concor wagons, bridges, structures etc.

SPECIAL INSTRUCTIONS

- Use welding grade CO2 Gas or 80% Argon + 20% CO2 gas mixture.
- Flow rate about 25 l/minute.
- Recommended stick out is between 15 to 25 mm.

WELDING CURRENT : DC (+)

SHIELDING GAS : CO2

RECOMMENDED CURRENT (AMPS)

Size (mm)	F & HF
1.2	200~350

PACKING PARAMETERS

Size (mm)	Weight / Spool (kg)
1.2	15