

STRONG 90S-D2

CLASSIFICATION: AWS SFA 5.28 ER 90S-D2

Copper Coated Solid Wire For MIG & TIG Welding



CHARACTERISTICS

STRONG 90S-D2 is a low alloy steel welding wire that gives stable arc, smooth welding performance and deposits radiographic quality welds. This wire is recommended for welding of high strength fine-grained structural steels containing molybdenum (~0.5%).

APPLICATIONS

STRONG 90S-D2 is highly suitable for welding low-alloy steels with high tensile strength and creep-resistant steels. Suitable for pipelines and pressure vessels with operating temperatures of about 500°C. This wire is also suitable for the repair of medium strength steel castings.

TYPICAL WIRE CHEMISTRY (%)

C	Mn	Si	P	S	Cu	Ni	Cr	Mo	V
0.07-0.12	1.60-2.10	0.50-0.80	0.025 MAX	0.025 MAX	0.50 MAX	0.15 MAX	0.15 MAX	0.40-0.60	0.03 MAX

ALL WELD MECHANICAL PROPERTIES

Required as per AWS 5.18	Y.S.	U.T.S.	ELONGATION	IMPACT VALUE AT -30°C
	MPa	MPa	%	JOULE
	≥540	≥620	≥17	≥27
Typical	592	685	22	75

PACKAGING SPECIFICATIONS - MIG

DIA SIZE 0.80MM / 1.00MM / 1.20MM / 1.60MM / 2.00MM

SPOOL WEIGHT 1KGS / 5KGS / 12.5KGS / 15KGS / 17.5KGS

DRUM WEIGHT 100KGS / 150KGS / 250KGS / 300KGS / 350KGS

PACKAGING SPECIFICATIONS - TIG

DIA SIZE 1.60MM / 2.00MM / 2.40MM / 3.15MM / 4.00MM

WEIGHT 5KGS / 20KGS