

# STRONG 90S-G

CLASSIFICATION: AWS SFA 5.28 ER 90S-G

## Copper Coated Solid Wire For MIG & TIG Welding



### CHARACTERISTICS

STRONG 90S-G is a copper coated high strength - low alloy steel wire with very low impurities that provides radiographic weld quality.

It provides an excellent weld bead appearance on flat or horizontal welding positions.

### APPLICATIONS

STRONG 90S-G is highly suitable for butt and fillet welding of high sulfur bearing machining steels, medium carbon steels, 0.5 Mo steels and high temperature resistant steels.

Typical applications in pipe lines, machinery construction and pressure vessels with operating temperatures of about 500°C.

### TYPICAL WIRE CHEMISTRY (%)

C	Mn	Si	P	S	Cu	Ni	Cr	Mo	V
0.07-0.10	1.70-1.90	0.50-0.70	0.020 MAX	0.020 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 5.28	Y.S.	U.T.S.	ELONGATION	IMPACT VALUE AT -30°C
	MPa	MPa	%	JOULE
	≥540	≥620	≥17	≥27
Typical	580	680	22	45

### 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