



# TIGFIL 90S-D2

GTAW LOW ALLOY STEEL (High Strength)

AWS A/SFA 5.28 ER90S-D2

### KEY FEATURES:

- Copper coated solid filler wire and rod
- Mn-0.5 Mo type welds deposit
- Uniform copper coating
- Mo addition for high strength
- High level of deoxidizers for defect free welds
- Excellent low temperature toughness
- Porosity free radiographic quality weld

### APPROVALS: IBR

### TYPICAL APPLICATIONS:

- Welding of high tensile steels like IS 8500 Gr.540B,570B & 590B, IS 2002 Gr.3, IS 1875 Class 3A
- Welding of Sailma 450/450Hi steel used in CONCOR wagon
- Suitable for single and multiple pass welding
- High temperature service pipe, fittings, flanges and valves


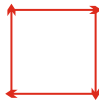
### TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Si	Mo
0.09	1.7	0.5	0.45

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -30°C, J
Typical	As Welded	640	580	20	50

### PARAMETERS - PACKING DATA:

Ø x L, mm	Net Wt., Kg		
1.6 x 1000	20	 <b>DCEN</b>  <b>STORAGE / HANDLING :</b> Keep dry and follow handling instructions mentioned on the box	All Positions  
2.0 x 1000	20		
2.4 x 1000	20		

Shielding Gas	Gas Flow Rate, LPM
Ar	10-15

Available in Standard carton packing of 20 kg box, containing 4 plastic tubes of 5 kg each.