

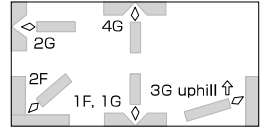
**Solid wire for Mn-Mo & Mn-Mo-Ni steel**

**Features:**      ■ Applied for ASTM A533 Type A, B, C, D class 2 and equivalents

**Classification:** AWS A5.28 ER90S-G

**Shielding gas:** Ar-5~20%CO<sub>2</sub>

**Polarity:**        DCEP

**Welding Positions:****Packaging data**

$\phi$ mm	Spool
1.2	20kg
<b>Volume mm</b>	280W, 110H, 270L

**Composition (wire mass%)**

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.08	0.15
<b>Si</b>	0.48	0.70
<b>Mn</b>	1.76	1.50~2.10
<b>P</b>	0.007	0.015
<b>S</b>	0.002	0.015
<b>Ni</b>	1.02	0.80~1.40
<b>Mo</b>	0.46	0.40~0.65
<b>Cu</b>	0.12	0.35

Note: <sup>a</sup> Single values are maximum.

**Welding parameters (A)**

$\phi$ mm	1F, 1G, 2F	2G, 3G uphill, 4G
1.2	240~300	130~190

**All-weld mechanical properties**

	Typical	Guaranty
<b>0.2%YS (MPa)</b>	570	-
<b>TS (MPa)</b>	650	621min.
<b>EI on 4d (%)</b>	27	-
<b>IV -12°C (J)</b>	150	-
<b>PWHT (°Cxh)</b>	630x27	620±15x1
<b>SG</b>	Ar-20%CO <sub>2</sub>	Ar-20%CO <sub>2</sub>