

TIG wire and rod for Mn-Mo and Mn-Mo-Ni steel

Features:	• Applied for ASTM A533 Type A, B, C, D and equivalents
Classification:	AWS A5.28 ER90S-G
Shielding Gas:	Ar
Identification color:	1st Light green
Polarity:	DCEN

Packaging data

φ mm	kg	Tube	
		Length mm	g/piece
1.6	5	1,000	16
2.0	5	1,000	25
2.4	5	1,000	35
3.2	5	1,000	63
Volume mm	40W, 35H, 1015L		

Composition (wire mass%)

	Typical	Guaranty ^a
C	0.12	0.15
Si	0.34	0.20~0.50
Mn	1.27	1.05~1.45
P	0.003	0.025
S	0.007	0.025
Ni	1.58	1.45~1.75
Cr	0.02	0.30
Mo	0.41	0.25~0.55
Cu	0.11	0.35
V	<0.01	0.05

Note: ^a Single values are maximum.**All-weld mechanical properties**

	Typical	Guaranty
0.2%YS (MPa)	566	530min.
TS (MPa)	655	621min.
EI on 4d (%)	27	15min.
IV -12°C (J)	256	-
PWHT (°C×h)	625×15	620×1