

AUTOMIG 90S-D2 (AUTOMIG-IV)

Classification

AWS A/SFA 5.28 : ER 90S-D2

AWSA/SFA 5.28M : ER62S-6

Approvals :

RDSO Class III

Characteristics

A copper coated MIG wire for MIG/MAG welding of High tensile steels. Uniform copper coating, smooth feeding, stable arc and minimum spatter under optimum welding conditions. Normally recommended with Ar/O₂ shielding. CO₂ shielding may also be used, with note of properties as given below.

Typical Applications

Widely used for the welding of High Tensile Steels like IS 8500 Grade 540B, 570B and 590B; IS 2002 Gr.III, IS 1875 Cl. IIIA. Welding of SAILMA 450 / 450H1 steel used in CONCOR wagons is a typical application for this wire.

Wire Chemistry

C	Mn	Si	S	P	Cu	Mo
0.07-0.12	1.60-2.10	0.50-0.80	0.025 max	0.025 max	0.50 max	0.40-0.60

Shielding Gas: Ar/CO₂, ArO₂ Current Condition: DC (+)

Classifications:

All Weld Mechanical Properties As welded condition

Shielding Gas	UTS	YS	Elongation	RA	CVN Impact, J	
	MPa	MPa	% (L=4×d)	%	-20° C	-30° C
Ar/1-5% O ₂	620-720	540-650	17 min	40-55	40-60	30-50

The chemistry and mechanical properties of the weld metal will vary with the type of shielding gas used.

Welding Positions

F, H, V-up, V-down, OH

Packing Data

Dia., mm	1.0	1.2	1.6
Plastic Spools, net wt Kg	15	15	15



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