

TIGFIL 90SG

Classification

AWSA/SFA 5. 28 : ER 90SG

Identification: AWS classification embossed at one end of the wire.

Characteristics

A copper coated low alloy GTAW filler/rod with 2.5% Cr & 1% Mo. It is characterized by smooth flow and gives shiny welds of radiographic quality.

Typical Applications

For welding of 2.25Cr-1Mo steels such as ASTM A-387 Gr. D, DIN steels, 10CrMo910, etc.

Wire Chemistry, wt %

C	Mn	Si	S	P	Mo	Cr
0.10 max	0.80-1.20	0.50-0.80	0.020 max	0.020 max	0.90-1.20	2.30-3.20

Properties of weld metal with 100% Argon gas shielding; **Current Condition:** DC (-)

All Weld Mechanical Properties After PWHT of 690°C for 1 hr.

UTS MPa	620 min
Yield strength MPa	540 min
Elongation % (L=4xd)	17 min
The chemistry & mechanical properties of the weld metal will vary with the type of shielding gas used.	

Packing Data

Dia (mm)	1.6	2.0	2.5
Length (mm)	1000	1000	1000
Primary Tube (Kg)	5	5	5
No. of Tubes	4	4	4
Secondary Cartons (Kg)	20	20	20

TIGFIL Wires are sealed in polyethylene bags and then packed in primary tubes.

TIGFIL Wires are also available in 5 Kg PSLW spools in 0.8, 1.0 and 1.2 mm sizes for orbital GTAW/TIG welding.

AUTOMIG 90SG, in spool form, available for GMAW process on demand.



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