

Classifications

EN ISO 16834-A:2007	: G 62 6 M Mn3Ni1Mo	JIS Z 3312	: G 62 A 6 U M N2M1T
EN ISO 16834-B:2007	: G 69A 6 U M N2M1T		
AWS A5.28-05	: ER90S-G		

Description

- For butt and fillet welding of machineries, heavy equipments, pressure vessels and steel that demand for creep-resistant in high temperature
- Superior arc stability and sound welds for X-ray test
- Stable weldability on high welding current
- Beautiful weld appearance due to low spatter

Typical chemical composition of wire (%)

C	Si	Mn	P	S	Ni	Mo
0.09	0.54	1.31	0.004	0.001	0.99	0.32

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -60℃	Remarks
AWS A5.28		min. 620			
EN ISO 16834-B	min. 600	690~890	min. 14	≥ 47	Mix
Example	660	740	21	60	Mix

Operating data

	Dia.(mm)	1.2	1.4
Current (Amp.)	Flat (PA/1G)	120 ~ 350	150 ~ 400
	Vertical (PF/3G)	80 ~ 180	100 ~ 250
	Overhead (PE/4G)	80 ~ 180	100 ~ 250

Polarity and Shielding gas

- DCEP (DC+)
- Mix : Ar+20% CO₂ (15~25ℓ /min.)