

## F 90S-D2

**CODIFICATION:**                      **AWS :**      SFA 5.28 ER90S-D2

### CHARACTERISTICS AND APPLICATIONS:

F 90S-D2 is a copper-coated solid wire available in bright finish. The wire gives stable arc, smooth welding performances and deposits radiographic quality welds. This wire is recommended for welding of molybdenum (~ 0.5%) containing high strength fine-grained structural steels. The wire also is suitable for welding of penstock pipe-line, fabrication of earth moving equipments, etc. where high tensile strength property is desired from the weld metal. Suitable for welding of ASTM steels: SA-455/ SA-455M, Gr.60, Gr.65, Gr.70 steels of SA-515/ SA-515M, Gr.60, Gr.65, Gr.70 steels of SA-516/ SA-516M, Class 1 of A grades of SA-533/ SA-533M, etc.

### TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Mo	Cu
%	0.075	1.78	0.55	0.014	0.015	0.45	0.15

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	YS (MPa)	Elongation (L=4d) %	CVN Impact Strength at minus 30°C (Joules)
680	560	22.0	55

**SHIELDING GAS:** Argon

**CURRENT CONDITIONS:** DCEN

**WELDING POSITION:** H, F, VU, OH

### PACKING:

**STANDARD SIZE**                      Diameter 1.6 mm, 2.0 mm, 2.4 mm & 3.2 mm in cut lengths of 500 mm / 1000 mm each.

**QUANTITY**                              5 kg wire put in an air-tight polythene bag and finally packed in a plastic container.

Identification – AWS code is punched on each wire.