

ROYAL –ER 90SD2 (ER 90SD2)

AWS –SFA A 5.28 ER 90SD2

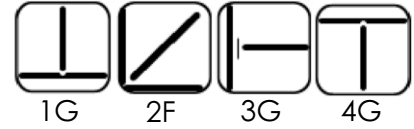
Applications

Highly suitable for welding low alloy steel with high tensile strength. Suitable for pipelines and pressure vessels. This wire is also suitable for the repair of medium strength steel casting.

Characteristics on Usage

Royal ER 90SD2 is a low alloy steel welding wire that gives stable arc, smooth welding performance and deposits radiographic quality welds. This wire is recommended for welding of high strength fine - grained structural steels containing molybdenum.

Welding Positions



Packing

Each Packet contains 5 kg of Wire Rods having length 1000 mm. Also available in spool form of 12.5 kg / 15 kgs per spool

MIG TIG WIRES

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo%	V%	Cu%
0.07-0.12	1.60-2.10	0.50-0.80	0.025 Max	0.025 Max	0.15 Max	0.15 Max	0.40-0.60	0.03 Max	0.50 Max

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	CVN IMPACT AT - 30° C (J)
620 Min	540 Min.	17.0 % Min	30 Joules Min