



Changzhou Giant Welding Co.,Ltd
www.giantweld.com

Standard: AWS A5.28 ER90S-G	Chemical Composition %									
	C	Mn	Si	P	S	Ti	Ni	Cu	Cr	B
Grade ER90S-G	≤0.11	1.40 ~ 1.70	0.50 ~ 0.80	≤0.025	≤0.025	≤0.20	-----	≤0.50	0.20 ~ 0.40	-----
Type	Spool （MIG）				Tube （TIG）					
Specification （MM）	0.8、0.9、1.0、1.2、1.6、2.0				1.6、2.0、2.4、3.2、4.0、5.0					
Package	S100 / 1kg S200 / 5kg S270,S300 / 15kg-20kg				5kg / box	10kg / box	length :1000MM			
Mechanical Properties	Tensile Strength Mpa		Yield Strength Mpa		Elongation A （%）		Impact Value KV2 (J) -30℃			
	≥ 620		-----		-----		-----			
	Diameter（MM）		0.8		1.0		1.2		1.6	
MIG Welding	Welding Current （A）		50 – 100		50 – 220		80 – 350		170 – 550	
	CO2Gas-flow （L/min）		15		15 – 20		15 – 25		20 – 25	
Performance characteristics	Carbon steel argon arc welding wire has excellent plasticity, toughness and crack resistance, especially low impact toughness at low temperature. Can be used for carbon steel and certain low-alloy steels.									
Application	1、Welding of various ≥ 620 Mpa tensile strength grade structural steel components.									
Notice	1、The product can be kept for two years under the condition of factory packing and sealed, and the packing can be removed for three months under the usual atmospheric environment. 2、Products should be stored in a ventilated, dry and place. 3、After the wire is removed from the package, it is recommended that appropriate dust proof cover be applied over the wire.									

