

**Classifications**

AWS A5.28-05	: ER90S-G
EN ISO 16834-A:2007	: W 62 6 M Mn3Ni1Mo
EN ISO 16834-B:2007	: W 69A 6 U M N2M1T
JIS Z 3316 : 2013	: W 62 A 6U N2M1T

**Description**

- For TIG welding of 620MPa high tensile steel used for pipe line, offshore, structure, construction machinery, pressure vessels, etc.
- Used for welding high strength steels in many high stress, critical applications; also exhibiting excellent toughness down to -60°C.
- Typical applications can be found in the mining, mobile cranes, cement pumps shipbuilding, automotive and pressure vessel industries.

**Typical chemical composition of rod (%)**

C	Si	Mn	P	S	Ni	Mo
0.08	0.61	1.60	0.014	0.002	0.86	0.38

**Typical mechanical properties of all-weld-metal**

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -60°C	Remarks
AWS A5.28	-	min. 620	-	-	As weld, Ar
EN 16834-A	min. 620	700~890	min. 18	≥47	As weld, Ar
EN 16834-B	min. 600	690~890	min. 14	≥47	As weld, Ar
Example	822	872	26	68	As weld, Ar

**Operating data**

Dia.(mm)	Voltage	Ampere
0.9	10~12	50~70
1.2	10~12	70~100
1.6	12~15	100~125
2.4	15~20	125~175
3.2	15~20	175~200

**Polarity and Shielding gas**

- DCEN (DC-)
- Ar : 100%Ar (15~25ℓ/min.)