

GTAW Solid Wire for High Tensile Strength Steel

TG-90

Classification

AWS	A5.28	ER90S-G
JIS	Z3316	W 59 A 2 3 3M1T
EN	636-A	W50 3 W0
GB	T 8110	ER62-G

Shielding Gas: Ar

Applications and Features

- (1) TG-90 is suitable for 550~620N/mm² grade high of pipe and plate in butt or fillet welding.
- (2) It is specially designed for TIG welding with Argon in the root pass of butt welding.

Welding Instruction

Please refer to Appendix C.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	P	S	Mo
0.050	0.67	1.89	0.012	0.011	0.43

Typical Mechanical Properties of Weld Metal

Tensile Strength N/mm ² (kgf/mm ²)	Yield Strength N/mm ² (kgf/mm ²)	Elongation %	Charpy V-Notch °C	J (kgf -m)
650(66.3)	560(57.1)	25	0	105(20.9)
			-30	86(20.0)

Size and Suggested Operating Range (DC+)

Diameter (mm)	1.2	1.4	1.6	2.0	2.4	2.6	3.2	4.0	4.8	5.0
Length (mm)	1000									