

GTAW Solid Wire for High Tensile Strength Steel

TG-90

Classification

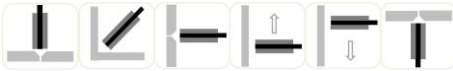
AWS A 5.18/A5.18M	ER90S-G/ ER62S-G
JIS Z3316	W62A33M1T
EN ISO 636-A	W 50 3 W0
GB T8110	ER62-G

Shielding Gas:100% Ar

Applications and Features

- (1) TG-90 is suitable for welding 620N/mm² grade steel.
- (2) TG-90 is an all-position welding rod for TIG welding. Especially suitable for root pass of pipe welding.
- (3) Ideal for welding pipeline of high-strength steels such as Mn steels and Mn-Mo steels.

Welding Position



Welding Instruction

Please refer to Appendix C.

Typical Chemical Composition of Wire (wt%)

C	Si	Mn	P	S	Mo
0.06	0.69	1.86	0.011	0.011	0.44

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
670	560	25	0	187
			-30	86

Size and Polarity (DC-)

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