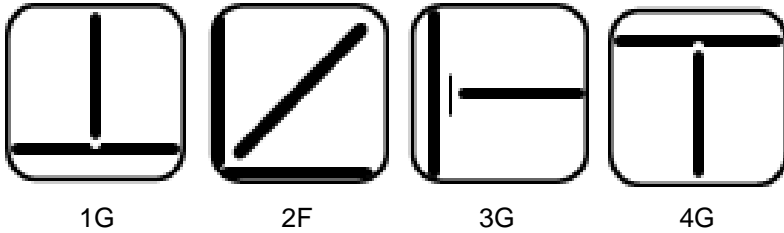


Applications

In general classification of metal requirements for welding of steel structures, pipe lines, construction of machinery, pressure vessels, where required strength 620 N/mm² min.

Characteristics on Usage

Royal ER 90SG is a solid wire for flat and horizontal fillet welding position. As the deposition rate very high, gives smooth flow, shiny weld beads of radiographic quality.

Welding Positions**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo
0.15	1.50	0.80	0.025	0.025	0.15	1.40	0.3

Mechanical Properties Of Weld Metal

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

Packing

Each Packets content 5 kg of Wire Rods having length 1000 mm.