

# ESL'ARC - 90S

## Classification

ER90S-D2 as per AWS A5.28-10

## Characteristics

ESL'ARC-90S is copper coated wire for MIG/MAG welding of steels to IS:2062-11 grade E410, E450 of all quality, IS:2002-01 Grade -III, IS: 1875-04 Class -IIIA or other equivalent steels. The weld shall be of radiographic quality.

## Chemical Composition for solid MIG/MAG Filler Wires:

C%	Mn.%	Si%	S%	P%	Cu%	Mo%	Ni%
0.07-0.12	1.60-2.10	0.50 - 0.80	0.025 Max.	0.025 Max.	0.20 - 0.40 <small>The Wt% of Copper includes Copper Coating of Wire and copper content in the weld metal</small>	0.40 - 0.60	0.15 Max

## Mechanical Properties (Average Value)

UTS	YS	Elongation	Impact	% Reduction in Area
590Min. N/mm <sup>2</sup>	450 N/mm <sup>2</sup> min	20Min.	27 at -20°CMin.	40Min.



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