

AK ER90S-G

Description: AK-ER90S-G is a copper-plated gas shielded welding wire for low alloy steel with a tensile strength of 600MPa. The weld metal has excellent comprehensive mechanical properties.

Application: Argon-rich (80%Ar+20%CO₂) gas shielded welding, mainly used in ships, pipelines, construction machinery, containers, petrochemicals, boilers and pressure vessels, bridges, lifting equipment, high-rise buildings and steel structures and other fields. Welding of low alloy steels.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Other	—	—	—
Actual Result	0.075	0.60	1.75	0.008	0.001	Moderate	—	—	—

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Actual Result	668	548	25	135J(-40°C)

Recommended welding parameters:

Diameter/ mm		0.8	1.0	1.2
Welding current /A	F/H	50-180	80-250	100-360
	V/OH	50-100	70-160	80-220