

Classifications

EN ISO 21952-A	EN ISO 636-A	EN ISO 636-B	AWS A5.28
W ZMn4MoSi	W 50 3 Z4MoSi	W4M31	ER90S-D2

Characteristics and typical fields of application

Medium-alloyed solid wire electrode / rod for welding of higher strength and low alloyed steels in boiler, tank, pipeline and reactor construction.

Base materials

P235GH – P460M, 16 Mo 3; S460N; S460MC; A36; A161-94 Gr. T1; A182M; A204M; A217; A250M; A285, A335 Gr. P1; A515 Gr. 70; A516 Gr. 70

Typical analysis of solid wire (wt.-%)

	C	Si	Mn	Mo
wt-%	0.09	0.65	1.80	0.52

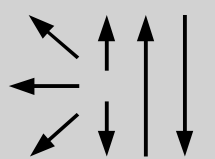
Mechanical properties of all-weld metal

Heat-treatment	Yield strength R _{p0.2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact value ISO-V KV J	
				-20 °C	-40 °C
u	590	700	25	150	-
s	510	600	18	80	47

u untreated / as welded – shielding gas Ar /I1

s stress relieved 610°C / 16h – shielding gas Ar /I1

Operating data

	Polarity: DC (-)	Shielding gas: (EN ISO 14175): I1; I3	Rod marking (Spark)ER90S-D2 // W4M31	ø mm 1.2 2,0 x 1000	Spool: BS300
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