

MERIT LMC-9

AWS 5.28 ER90S-G



Merit™ LMC90-G is a copper coated MIG wire that is an excellent choice for single and multi-pass welding on carbon and low-alloy steels. Shielding gases used can be 100% CO₂.

KEY FEATURES

- Excellent drawing and copper coating techniques ensure good Feedability.
- Will support all the traditional modes of GMAW metal transfer: short-circuiting, and pulsed spray.
- Precision layer wound spools are well suited for applications where accurate and consistent wire feeding is necessary.
- Excellent bead profile.

APPLICATIONS

- Pressure vessel forging and valves

WELDING POSITIONS

All

CONFORMANCE

AWS SFA 5.28, ASME Section-II Part-C SFA 5.28

Dia, mm	Coil, Kg	Drum, Kg	Product no
1.2	15		ICMO9120
1.2		250	ICMO9122

WIRE COMPOSITION ⁽¹⁾ – As required per AWS SFA 5.28, ASME Section-II Part-C SFA 5.28

CHEMICAL COMPOSITION, ELECTRODE						
	% C	% Mn	% Si	% S	% P	% Cu (Total)
Requirements - AWS	NA	NA	NA	NA	NA	NA
⁽²⁾ Typical results	0.07-0.12	1.60-2.10	0.50-0.80	0.025 max	0.025 max	0.10 max

	% Mo	% Ni
Requirements - AWS ER90S-D2	NA	NA
⁽²⁾ Typical results	0.40-0.60	0.15 max

MECHANICAL PROPERTIES OF ALL WELD METAL

	Tensile strength MPa	Yield Strength MPa	Elongation (%)	Charpy V-Notch, J (ft.lbf) @-30°C
Requirements - AWS ER90S-G	620 min	--	--	27 (20) min
⁽²⁾ Typical results- As welded 100% CO2	644	547	24	51 (46)

(1) Single values are maximums.

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

CUSTOMER ASSISTANCE POLICY

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