

# SuperArc® LA-90

Low Alloy, Copper Coated • AWS ER80S-D2, ER90S-D2 & EA3K

## Key Features

- ▶ Capable of producing weld deposits with 550 - 620 MPa (80 - 90 ksi) tensile strength
- ▶ Contains 0.50% molybdenum for strength after stress-relief
- ▶ MicroGuard® Ultra provides superior feeding and arc stability
- ▶ Supports short-circuiting, globular, axial spray and pulsed spray transfer

## Typical Applications

- ▶ Requirements for strength after stress relieving
- ▶ ASTM A182, A217, A234 and A335 high temperature service pipe, fittings, flanges and valves
- ▶ ASTM A336 pressure vessel forgings

## Conformances

AWS A5.28/A5.28M: 2005	ER80S-D2 (100% CO <sub>2</sub> ), ER90S-D2 (Mixed)
ASME SFA-A5.28:	ER80S-D2 (100% CO <sub>2</sub> ), ER90S-D2 (Mixed)
AWS A5.23/A5.23M: 2007	EA3K
CWB/CSA W48-06:	ER55S-D2 (ER80S-D2), ER62S-D2 (ER90S-D2)
EN ISO 16484-B:	G 59A 3 C 4M31
EN ISO 16834-B:	G 62A 3 A 4M31
MIL-E-23765/2:	MIL-80S-3

## Welding Positions

All

## Shielding Gas

100% CO<sub>2</sub>  
 75-95% Argon / Balance CO<sub>2</sub>  
 95-98% Argon / Balance O<sub>2</sub>  
 Flow Rate: 30 - 50 CFH

## DIAMETERS / PACKAGING

Diameter in (mm)		33 lb (15 kg) Steel Spool	44 lb (20 kg) Steel Spool	44 lb (20 kg) Fiber Spool
0.035	(0.9)	ED031413 ED031414	EDS30775	ED029546
0.045	(1.1)		EDS30776	
0.052	(1.3)		EDS30777	
1/16	(1.6)			
Diameter in (mm)		60 lb (27.2 kg) Coil	60 lb (27.2 kg) Fiber Spool	500 lb (227 kg) Accu-Trak® Drum
0.035	(0.9)	ED013999	EDS01380	EDS01372
0.045	(1.1)			ED001378
0.052	(1.3)			ED026627
1/16	(1.6)			
Diameter in (mm)		500 lb (227 kg) Accu-Pak® Box	1000 lb (454 kg) Accu-Trak® Drum	
0.035	(0.9)	ED032919 ED032920	EDS29590	
0.045	(1.1)		ED029591	
0.052	(1.3)		EDS29592	
1/16	(1.6)			