

SC-90M

Type : Metal-Cored

Conformances

AWS A5.36/ ASME SFA5.36 E90T15-M21A6-G

(AWS A5.28/ ASME SFA5.28 E90C-G)

EN ISO 18276-A-T 55 Z Z M M21 1 H5

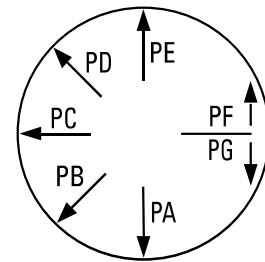
Applications

- Structural fabrication
- Robotic welding

Features

- Low temperature
- Low spatter
- Good anti-porosity

Welding Position



Current

DC +

Shielding Gas

Ar + 20~25% CO₂

Diameter / Packaging

Diameter	Spool			Pac		
	5kg (11lbs)	15kg (33lbs)	20kg (44lbs)	250kg (551lbs)	300kg (661lbs)	350kg (771lbs)
mm (in)						
1.2 (0.045)	√	√	√	√	√	√
1.4 (0.052)	√	√	√	√	√	√

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni	Mo
0.07	0.54	1.35	0.012	0.007	1.17	0.18

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft·lbs)
633 (91,800)	672 (97,500)	25	-50 (-58)	88 (65)

Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)	Efficiency (%)
1.2mm (0.045 in) DC+						
Flat & Horizontal						
80% Ar + 20% CO ₂	19-25 (3/4-1)	9.8 (385)	240~260	25~27	3.9 (8.6)	90~96
		13.1 (515)	270~290	27~29	5.4 (11.6)	
		14.6 (574)	320~340	29~31	6.2 (14.2)	
1.4mm (0.052 in) DC+						
Flat & Horizontal						
80% Ar + 20% CO ₂	19-25 (3/4-1)	9.7 (381)	280~300	26~28	5.2 (11.6)	92~97
		12.8 (503)	310~330	28~30	7.4 (15.9)	
		15.6 (614)	350~370	30~32	8.8 (19.2)	