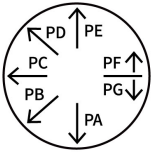


SC-90M

Classification

**AWS** AWS A5.28/ ASME SFA-5.28 E90C-G  
**EN** ISO 18276-A T55 5 ZMn1NiMo M M21 1 H5

Welding Positions



Features

- Designed for welding with Ar+CO2 mixed gas
- Good impact value at Low temperature(-50℃)

Polarity

DC+

Application Areas

- Structural fabrication
- Steel industry
- Heavy equipment

Shielding Gas

Ar+20~25% CO2

Approvals

|    |
|----|
| CE |
| ✓  |

Typical Chemical Composition of All-Weld Metal (wt%)

| Shielding Gas | C    | Si   | Mn   | P     | S     | Ni   | Mo   |
|---------------|------|------|------|-------|-------|------|------|
| Ar+20~25% CO2 | 0.06 | 0.60 | 1.55 | 0.010 | 0.007 | 1.12 | 0.19 |

Typical Mechanical Properties of All-Weld Metal

| Shielding Gas | Yield Strength<br>MPa(ksi) | Tensile Strength<br>MPa(ksi) | Elongation<br>(%) | Temperature<br>℃ (°F) | Impact Toughness<br>J (ft · lbs) |
|---------------|----------------------------|------------------------------|-------------------|-----------------------|----------------------------------|
| Ar+20~25% CO2 | 634 (92)                   | 706 (102)                    | 24.8              | -50 (-60)             | 66 (49)                          |

Diameter / Welding Parameters / Packaging

| Wire Diameter<br>mm(in) | Current<br>(A) |
|-------------------------|----------------|
| 1.2 (0.045)             | 200~300        |

SAW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux