

Applications

Butt and fillet welding of steel structures using 600MPa or HSB 600 steel class high tensile steels.

Characteristics on Usage

SC-90 is a metal type flux cored wire for high speed welding application in the flat and horizontal fillet position.

Arc stability is excellent, spatter loss is low and slag covering is uniform with good removability.

Notes on Usage

- ① Proper preheating 50~150°C(122~302°F) and interpass temperature must be used in order to release hydrogen which may cause cracking in weld metal when electrodes are used for medium and heavy plates.
- ② Use 100% CO₂ gas.

Welding Position



1G 2F
(PA) (PB)

Current

DC +

Shielding Gas

100%CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni	Mo
0.08	0.55	1.75	0.014	0.014	0.35	0.12

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)
600 (87,100)	660 (95,800)	22.5	-20 (-4)	60 (44)

Approval

I Packing(Including Ball Pac)

Dia. (mm)	1.2	1.4	1.6	Spool(kg)	12.5	15	20
(in)	.045	.052	1/16	(lbs)	28	33	44

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.2 (.045)	1.4 (.052)	1.6 (1/16)
F & HF	250 ~ 300	300 ~ 350	300 ~ 350