



## **M-90 E6012**

### **FEATURES**

- \*OFFER EXCELLENT BRIDGING CHARACTERISTICS
- \*GOOD STABLE ARC AND OPERATES AT HIGH CURRENT WITH LOW SPATTER.
- \*CAN BE USED WITH BOTH AC AND DC POWER

### **APPLICATION**

FARM IMPLEMENTS, GENERAL REPAIR, MACHINERY FABRICATION, METAL FURNITURE, ORNAMENTAL IRON, SHEET METAL, TANKS

### **CLASSIFICATION**

\*AWS/A5.1/ASME SFA5.1 E6012

### **CHEMICAL COMPOSITIONS**

C	Si	Mn	P	S	CR	Ni	MO
0.05	0.23	0.35	0.022	0.017			

### **MECHANICAL PROPERTIES**

Y.S	T.S	EL	Temp.	CVN-Impact Value
N/mm2 (lbs/in 2 )	N/mm2 (lbs/in 2 )	(%)	oC ( oF)	J (ft lbs)
436 (63,300)	489 (71,000)	26.9	0 (32)	98 (73)

### **WELDING PARAMETERS**

DIAMETER (mm)	1.6	2	2.5	3.2	4	5
LENGTH (mm)	300	300	300	350	350	400
CURRENT (amps)	50-70	55-70	50-90	80-120	100-160	120-220

### **CURRENT**

\*AC or DC +

## WELDING POSITIONS

