

CSM-90T

For 620N/mm² class high tensile strength steel

AWS	A5.29	E90T1-GC
KS	D 7104	YFW-C602M
JIS	Z3313	T622T15-OCA-N2-H10

Applications

Butt, fillet welding of 620N/mm² high tensile strength steels of structure such as ships, bridges, buildings and storage tanks etc.

Characteristics

- (1) CSM-90T is a metal type flux cored wire for flat & horizontal fillet welding with CO₂ gas shielding.
- (2) Its deposition rate is 10~30% higher compared with a solid wire, so total cost is saved.
- (3) It provides excellent usability with stable arc, less spattering better bead appearance and less quantity of welding fume comparable to solid wire.

Notes on usage

- (1) The optimum flow of CO₂ for shielding is 20~25ℓ/min.
- (2) The distance between tip & base metal is to be 15~25mm.
- (3) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.
- (4) Thick heavy plate should be welded under proper preheating & interpass temperature.

Typical chemical composition of weld metal (%)

(Shielding gas : 100%CO₂)

C	Mn	Si	P	S	Ni	Mo
0.06	1.60	0.65	0.014	0.012	0.89	0.16

Typical mechanical properties of weld metal

(Shielding gas : 100%CO₂)

YP N/mm ² (MPa)	TS N/mm ² (MPa)	EL %	IV (J)	
			-20℃	-30℃
584	693	24.0	56	47

Size & recommended current range (DC +)

Dia. mm (in)		1.2 (0.045)	1.4 (0.052)	1.6 (0.062)
Amp.	F & H-F	180~340	200~360	200~400