



Tru-Core[®] MC 90C-D2 AWS E90C-D2 H4

DESCRIPTION

Tru-Core[®] MC 90C-D2 is a low alloy steel, composite metal cored electrode for gas shielded arc welding of low alloy, and certain carbon, steels requiring tensile strengths in excess of 90 ksi and good CVN values at temperatures as low as -20°F. This electrode is intended to be used with shielding gas blends of 75-95% Argon/Balance Carbon Dioxide, and up to 98% Argon/Balance Oxygen (the AWS Classification gas blend). As the core is comprised entirely of metallic powders, this electrode is used within the GMAW process. The MC 90C-D2 can be used in single and multiple pass applications, both in fillets and groove welds.

CHARACTERISTICS

PRODUCT FEATURES:

- Excellent mechanical properties
- Nearly slag free welds
- Flat bead geometry
- Smooth arc transfer
- Low fume emissions
- Excellent feedability
- Virtually no spatter
- Wide window of operating parameters
- Good low-temperature CVN properties
- Better sidewall fusion than solid electrodes

PRODUCED IN: Stillwater, Oklahoma

SPECIFICATIONS

Meets or Exceeds:

- AWS A5.28: E90C-D2 H4
- ASME SFA 5.28: E90C-D2 H4

APPLICATIONS

Tru-Core[®] MC 90C-D2 is a good choice to weld steels from ¼" thickness up to heavy plates sections, in grades matching the mechanical properties and corrosion resistance of high strength, low alloy pressure vessel steels, such as ASTM A302, and manganese molybdenum castings such as ASTM A49 , A291, and A735. Some typical applications are as follows:

- Pressure vessels
- Pressure piping systems
- Repair of manganese-molybdenum castings
- Crane frames and components

SHIELDING GAS BLENDS

Typical Application Shielding Gas Blends:

- 75-95% Argon/Balance CO₂
- 95-98% Argon/Balance O₂
- Flow Rate: 40-55 cfh

WELDING POSITIONS

All position welding is possible when using the correct shielding gas blends, welding process and welding parameters.

STORAGE

Welding wire should be stored in a dry, enclosed environment and in its originally-sealed package.

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