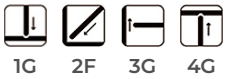
SC-81M

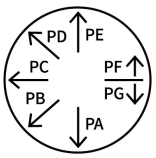
Classification

AWS AWS A5.29 / ASME SFA-5.29 E81T1-Ni1M-J H4

EN ISO 17632-A T50 6 1Ni P M21 1 H5

Welding Positions





Features

- Designed for welding with Ar+20~25%CO2 shielding gas
- Smooth and stable arc with a fast freezing slag
- Good impact value at low temperature

Polarity

DC+

Application Areas

- Construction machinery
- Bridge structures
- Mining

Shielding Gas

Ar+20~25% CO2

Approvals

CE
✓

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

Shielding Gas	C	Si	Mn	P	S	Ni
Ar+20~25% CO2	0.04	0.32	1.15	0.010	0.010	0.90

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
Ar+20~25% CO2	540(78)	580(84)	25	-40(-40) -60(-75)	105(77) 73(54)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)	Packaging
1.2 (0.045)	110~280	Spool 5kg (11lbs), 12.5kg (28lbs), 15kg (33lbs), 20kg (44lbs) Drum 100kg (221lbs), 200kg (441lbs), 250kg (551lbs)
1.4 (0.052)	110~280	
1.6 (1/16)	120~300	