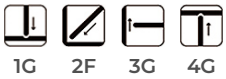
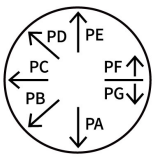
SC-81SR

Classification

AWS AWS A5.29 / ASME SFA-5.29 E81T1-K2C
JIS Z 3313 T55 6 T1-1 C A-N3-U
EN ISO 17632-A T46 6 1.5Ni P C1 1 H5

Welding Positions





Features

- Designed for welding with 100%CO2 shielding gas
- Good impact value at low temperature (As Welded and PHWT)

Polarity

DC+

Application Areas

- Shipbuilding
- Offshore structure
- Pressure vessel

Shielding Gas

100% CO2

Approvals

ABS	DNV	LR
✓	✓	✓

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

Shielding Gas	C	Si	Mn	P	S	Ni
100% CO2	0.05	0.28	1.20	0.010	0.010	1.50

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Condition	Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
100% CO2	As Welded	580(84)	620(90)	28	-30 (-20) -60 (-75)	125(92) 90(66)
100% CO2	PWHT 620°C×2hr	560(81)	600(87)	32	-30 (-20) -60 (-75)	90(66) 70(52)

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)