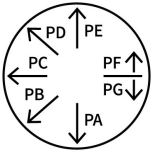


SC-81WM

Classification

**AWS** AWS A5.29 / ASME SFA-5.29 E81T1-W2M  
**EN** ISO 17632-A T50 3 ZCrNiCu P M21 1 H5

Welding Positions



Features

- Designed for welding with Ar+20~25%CO2 shielding gas
- Slag covering is uniform and easy to remove.
- Corrosion resistance of weathering steels

Polarity

DC +

Application Areas

- Structural fabrication

Shielding Gas

Ar+20~25% CO2

Approvals

|    |
|----|
| CE |
| ✓  |

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

| Shielding Gas | C    | Si   | Mn   | P     | S     | Cu  | Ni   | Cr   |
|---------------|------|------|------|-------|-------|-----|------|------|
| Ar+20~25%CO2  | 0.04 | 0.38 | 1.04 | 0.005 | 0.004 | 0.4 | 0.55 | 0.54 |
| 2             |      |      |      |       |       |     |      |      |

Typical Mechanical Properties of All-Weld Metal

| Shielding Gas | Yield Strength<br>MPa(ksi) | Tensile Strength<br>MPa(ksi) | Elongation<br>(%) | Temperature<br>°C (°F) | Impact Toughness<br>J (ft · lbs) |
|---------------|----------------------------|------------------------------|-------------------|------------------------|----------------------------------|
| Ar+20~25%CO2  | 620 (90)                   | 671 (97)                     | 24.9              | -30 (-20)              | 60 (44)                          |

Diameter / Welding Parameters / Packaging

| Wire Diameter<br>mm(in) | Current<br>(A) | Packaging                                                                                                            |
|-------------------------|----------------|----------------------------------------------------------------------------------------------------------------------|
| 1.2 (0.045)             | 110~280        | Spool 5kg (11lbs), 12.5kg (28lbs), 15kg (33lbs), 20kg (44lbs)<br>Drum 100kg (221lbs), 200kg (441lbs), 250kg (551lbs) |