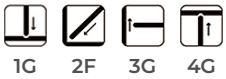
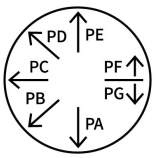
SC-91K2 Cored

Classification

AWS AWS A5.29 / ASME SFA-5.29 E91T1-K2C
JIS Z 3313 T57 4 T1-1 C A-N3
EN ISO 17632-A T 50 4 1.5Ni P C1 1
KS D7104 YFW-C602R

Welding Positions





Features

- Designed for welding with 100% CO2 shielding gas
- Smooth and stable arc and good weldability

Polarity

DC +

Application Areas

- General fabrication
- Structural fabrication

Shielding Gas

100% CO2

Approvals

ABS	CCS	DNV	CWB
✓	✓	✓	✓

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

Shielding Gas	C	Si	Mn	P	S	Ni	Mo
100% CO2	0.04	0.35	1.25	0.011	0.011	1.55	0.09

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)
100% CO2	620 (90)	650 (94)	27	-20 (0) -40 (-40)	110 (81) 60 (44)

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	