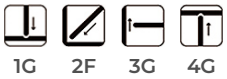
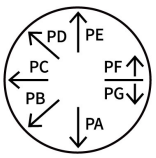
SC-91LP

Classification

AWS AWS A5.29 / ASME SFA-5.29 E91T1-GM
EN ISO 17632-A T50 4 1Ni P M21 1 H5

Welding Positions





Features

- Designed for welding with Ar+20~25%CO2 shielding gas
- Good performance in all positions (Pipe welding)
- Good impact value at low temperature

Polarity

DC +

Application Areas

- Pipe & Pipeline
- General fabrication
- Structural fabrication

Shielding Gas

Ar+20~25% CO2

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

Shielding Gas	C	Si	Mn	P	S	Ni
Ar+20~25% CO2	0.05	0.40	1.40	0.011	0.011	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	650 (94)	690 (100)	24	-40 (-40)	65 (48)

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)