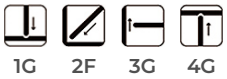
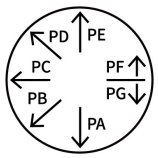
SF-80W

Classification

AWS AWS A5.29 / ASME SFA-5.29 E81T1-W2C
JIS Z 3320 T55 3 T1-1 C A-NCC1 H10
EN ISO 17632-B
T55 3 T1-1 C1 A-NCC1

Welding Positions





Features

- Designed for welding with 100% CO2 shielding gas
- All position welding of bridges, building using atmospheric corrosion resisting steels

Polarity

DC +

Application Areas

- Structural fabrication

Shielding Gas

100% CO2

Approvals

CE
✓

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

Shielding Gas	C	Si	Mn	P	S	Cu	Ni	Cr
100% CO2	0.04	0.40	0.92	0.011	0.011	0.4	0.50	0.52

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	540 (75)	615 (84)	28	-20 (0) -30 (-20)	66 (49) 46 (34)

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	