

SC-80D2

Type : Metal-Cored

Conformances

AWS A5.36/ ASME SFA5.36 E80T15-M21A0-G

(AWS A5.28/ ASME SFA5.28 E80C-G)

JIS Z3318 YFM-G

EN ISO 17632-A-T 46 0 MnMo M M21 3

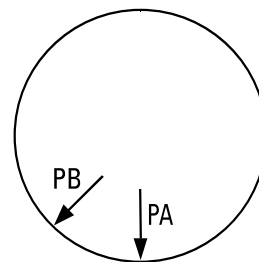
Applications

- Heavy equipment
- Petrochemical industry
- Pressure vessel

Features

- Smooth and stable arc
- Low spatter
- Good crack resistance
- Good impact value
- Good porosity resistance

Welding Position



Current

DC +

Shielding Gas

Ar + 20~25% CO₂

Diameter / Packaging

| Diameter | Spool | | | Pac | | |
|-------------|-------------|--------------|--------------|----------------|----------------|----------------|
| | 5kg (11lbs) | 15kg (33lbs) | 20kg (44lbs) | 250kg (551lbs) | 300kg (661lbs) | 350kg (771lbs) |
| mm (in) | | | | | | |
| 1.2 (0.045) | √ | √ | √ | √ | √ | √ |

Typical Chemical Composition of All-Weld Metal (%)

| C | Si | Mn | P | S | Mo |
|------|------|------|-------|-------|------|
| 0.05 | 0.61 | 1.62 | 0.012 | 0.010 | 0.50 |

Typical Mechanical Properties of All-Weld Metal

| YS MPa(lbs/in ²) | TS MPa(lbs/in ²) | EL (%) | Temp °C(°F) | CVN-Impact Value J (ft·lbs) |
|---------------------------------|---------------------------------|-----------|----------------|--------------------------------|
| 604 (85,600) | 675 (95,700) | 27 | -20 (-4) | 60 (44) |

Typical Welding Parameters

| Diameter, Polarity Shielding Gas | CTWD mm (in) | Wire Feed Speed m/min (in/min) | Amp. (A) | Volt. (V) | Deposition Rate kg/hr (lb/hr) | Efficiency (%) |
|-------------------------------------|------------------|-----------------------------------|-------------|--------------|----------------------------------|-------------------|
| 1.2mm (0.045 in) DC+ | | | | | | |
| Flat & Horizontal | | | | | | |
| 80% Ar + 20% CO ₂ | 19-25 (3/4-1) | 7.8 (307) | 240~260 | 22~26 | 3.5 (7.5) | 90~96 |
| | | 9.4 (374) | 270~290 | 22~27 | 4.0 (9.2) | |
| | | 10.3 (405) | 300~320 | 23~27 | 4.5 (10.8) | |

SMAW

SAW

GMW

GTAW

FCAW

Non-FERROUS

APPENDIX