

# SC-EG3

Type : Metal-Cored

## Conformances

AWS A5.26/ ASME SFA5.26 EG82T-NM2  
 KR 4Y40V H5  
 ABS 5Y400 H5  
 LR 5Y40<sup>2</sup>, 4Y<sup>2</sup>  
 BV AV5Y40 HHH  
 DNV·GL VY40(H5)  
 NK KEW54Y40G(C) H5 (-60°C ≥39J)  
 CCS 4Y40 H5

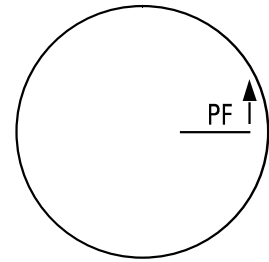
## Applications

- Shipbuilding
- LPG and LNG storage tank

## Features

- Electro gas arc welding process
- High deposition(vertical up butt welding)
- Low temperature service

## Welding Position



## Current

DC +

## Shielding Gas

100% CO<sub>2</sub>

## Diameter / Packaging

Diameter	Spool
mm (in)	20kg (44lbs)
1.6 (1/16)	√

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

C	Si	Mn	P	S	Ni
0.07	0.22	1.52	0.012	0.010	1.8

## Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)
575 (83,400)	672 (94,500)	23.5	-60 (76)	50 (37)

## 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 (%)
1.6mm (1/16 in) DC+						
100% CO <sub>2</sub>	25 (1)	8.2 (323)	330	32	5.5 (12.1)	91~93
		8.6 (346)	350	34	6.2 (14.6)	91~93
		9.6 (378)	380	38	6.8 (15.0)	92~94

SMWV

SAW

GMWV

GTAW

FCWV

Non-FERROUS

APPENDIX