SF-80MX

Type : Semi-Metal

Conformances

AWS A5.36/ ASME SFA5.36 E80T1-C1A2-G

(AWS A5.29/ ASME SFA5.29 E80T1-GC)

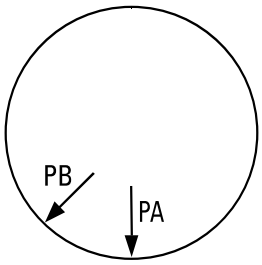
JIS Z3313 T55 2 T1-0 C A-N2 H10

EN ISO 17632-A-T 46 2 1Ni R C1 3

Applications

- Structural fabrication
- High tensile steel(590MPa steel class)
- Steel industry

Welding Position



Features

- Good deposition rate
- Good penetration and good arc stability

Current

DC +

Shielding Gas

100% CO_2

Diameter / Packaging

Diameter	Spool			Pac		
mm (in)	5kg (11lbs)	15kg (33lbs)	20kg (44lbs)	100kg (221lbs)	250kg (551lbs)	300kg (661lbs)
1.2 (0.045)	√	√		√	√	√
1.4 (0.052)	√	√		√	√	√
1.6 (1/16)	√	√		√	√	√

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni
0.06	0.55	1.42	0.015	0.010	1.00

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in²)	TS MPa(lbs/in²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft·lbs)
590 (85,600)	630 (91,400)	24	-20 (-4)	53 (39)

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+						
100% CO_2	20~25 (51/64~1)	11.5 (450)	225	26	4.1 (9.0)	85~86
		12.5 (480)	245	29	4.4 (9.7)	87~88
		14.2 (560)	265	30	4.9 (10.8)	87~89
		15.2 (610)	285	31	5.4 (11.9)	89~90
1.4mm (0.052 in) DC+						
100% CO_2	20~25 (51/64~1)	9.6 (380)	255	26	4.4 (9.8)	87~88
		10.6 (420)	275	27	5.0 (11.0)	87~88
		12.1 (480)	295	31	5.5 (12.1)	88~89
		12.7 (500)	325	32	5.8 (12.8)	88~90
		13.1 (515)	350	32	6.1 (13.4)	88~90
1.6mm (1/16 in) DC+						
100% CO_2	20~25 (51/64~1)	6.4 (250)	270	28	3.8 (8.5)	86~88
		7.3 (290)	295	32	4.6 (10.1)	87~89
		8.6 (340)	335	32	5.6 (12.3)	87~89
		10.0 (390)	360	35	6.4 (14.1)	89~91