

Supercored 1CM

Type : Metal-Cored

Conformances

AWS A5.36/ ASME SFA5.36 E80T15-M21PZ-G(B2)
(AWS A5.28/ ASME SFA5.28 E80C-G)
JIS Z3318 YF1CM-G
EN ISO 17634-A-T CrMo1 M M21 3

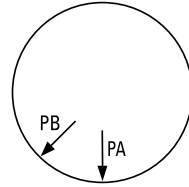
Applications

- Petrochemical industry
- Pressure vessel

Features

- Smooth and stable arc
- Low spatter
- 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)	5kg (11lbs)	15kg (33lbs)	20kg (44lbs)	250kg (551lbs)	300kg (661lbs)	350kg (771lbs)
1.2 (0.045)	√	√	√	√	√	√

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Mo
0.07	0.39	0.81	0.013	0.010	1.25	0.51

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)	PWHT
560 (81,300)	630 (91,400)	20	0 (32)	90 (66)	620/1Hr
510 (74,100)	600 (87,100)	25	0 (32)	110 (81)	620/8Hr

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)	9.5 (374)	230-250	26-29	3.9 (8.6)	90-96
		12.2 (480)	280-300	28-31	5.3 (11.6)	
		14.8 (582)	320-340	30-33	6.5 (14.2)	

SWAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX