

SC-55F Cored

Type : Semi-Metal

Conformances

AWS A5.36/ ASME SFA5.36 E80T1-C1A0-G

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

JIS Z3313 T55 2 T1-0 C A-N1-U H10

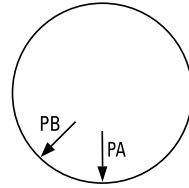
Applications

- Structural fabrication
- Storage tank
- Bridge construction
- Steel industry

Features

- Minimum spatter level
- Easy to remove slag
- Good anti-porosity

Welding Position



Current

DC +

Shielding Gas

100% CO₂

Diameter / Packaging

Diameter mm (in)	Spool			Pac		
	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
0.05	0.48	1.56	0.012	0.010

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)
580 (84,200)	625 (90,600)	24.5	-20 (-4)	75 (58)

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

SWAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX