

# 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

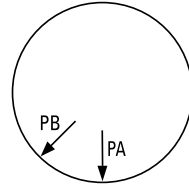
## Applications

- 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% CO<sub>2</sub>

## 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	Mo
0.05	0.61	1.62	0.012	0.010	0.50

**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)
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 (%)
<b>1.2mm (0.045 in) DC+</b>						
<b>Flat &amp; Horizontal</b>						
80% Ar + 20% CO <sub>2</sub>	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)	

SWAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX