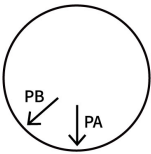


SC-55F Cored

Classification

AWS AWS A5.29 / ASME SFA-5.29 E80TI-GC
JIS Z 3313 T55 2 TI-O C A-N1-U
KS D7104 YFW-C55DM

Welding Positions



Features

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

Polarity

DC +

Application Areas

- Steel Fabrication

Shielding Gas

100% CO2

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

Shielding Gas	C	Si	Mn	P	S
100% CO2	0.05	0.48	1.56	0.012	0.010

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft · lbs)
100% CO2	545 (79)	610 (88)	24.5	0 (32) -20 (0)	89 (66) 78 (58)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)	Packaging
1.2 (0.045)	200~350	Spool 5kg (11lbs), 12.5kg (28lbs), 15kg (33lbs), 20kg (44lbs) Drum 100kg (221lbs), 200kg (441lbs), 250kg (551lbs)
1.4 (0.052)	300~380	
1.6 (1/16)	300~400	

SMW

GMAW

GTAW

FCW

Metal-cored Wire

SAW Wire

SAW Flux