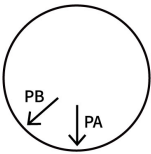


SC-80K2

Classification

AWS AWS A5.29 / ASME SFA-5.29 E80T1-K2C
JIS Z 3313 T55 6 TI-O C A-N3
EN ISO 17632-A-T 46 6 1.5Ni R C1 3 H5
KS D 7104 YFL- C506R

Welding Positions



Features

- High speed single or twin tandem welding
- Low hydrogen level (H4)
- Low temperature service

Polarity

DC+

Application Areas

- Shipbuilding
- LPG and LNG storage tank
- Offshore structure

Shielding Gas

100% CO2

Approvals

ABS	BV	CCS	DNV	KR	LR	NK	RS
✓	✓	✓	✓	✓	✓	✓	✓

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

Shielding Gas	C	Si	Mn	P	S	Ni
100% CO2	0.06	0.48	1.48	0.011	0.008	1.50

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	580(84)	640(93)	26	-40(-40) -60(-75)	103(76) 65(48)

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	

SMW

GMW

GTW

FCW

Metal-cored Wire

SAW Wire

SAW Flux