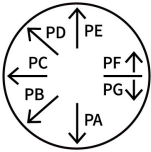


SC-81B2

Classification

AWS AWS A5.29 / ASME SFA-5.29 E81T1-B2C
EN ISO 17634-B T55 T1-1C1-1CM

Welding Positions



Features

- Designed for welding with 100%CO2 shielding gas
- 1.25%Cr-0.5%Mo type heat resistant steel steel
- Stable arc and low spatter level

Polarity

DC+

Application Areas

- Petrochemical industry
- Pressure vessel

Shielding Gas

100% CO2

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

Shielding Gas	C	Si	Mn	P	S	Cr	Mo
100% CO2	0.06	0.40	0.83	0.015	0.009	1.20	0.50

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Condition	Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)
100% CO2	PWHT 690±15°C x 1hr	575(83)	655(95)	22

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)	Packaging
1.2 (0.045)	120~300	Spool 5kg(11lbs), 12.5(27.6lbs), 15kg(33lbs)
1.4 (0.052)	200~350	
1.6 (1/16)	200~400	

SMW

GMW

GTW

FCW

Metal-cored Wire

SAW Wire

SAW Flux