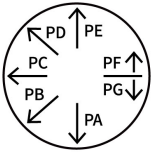
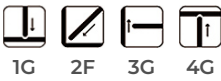


SC-81WM

Classification

AWS AWS A5.29 / ASME SFA-5.29 E81T1-W2M
EN ISO 17632-A T50 3 ZCrNiCu P M21 1 H5

Welding Positions



Features

- Designed for welding with Ar+20~25%CO2 shielding gas
- Slag covering is uniform and easy to remove.
- Corrosion resistance of weathering steels

Polarity

DC +

Application Areas

- Structural fabrication

Shielding Gas

Ar+20~25% CO2

Approvals

CE
✓

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

Shielding Gas	C	Si	Mn	P	S	Cu	Ni	Cr
Ar+20~25%CO2	0.04	0.38	1.04	0.005	0.004	0.4	0.55	0.54
2								

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)
Ar+20~25%CO2	620 (90)	671 (97)	24.9	-30 (-20)	60 (44)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)	Packaging
1.2 (0.045)	110~280	Spool 5kg (11lbs), 12.5kg (28lbs), 15kg (33lbs), 20kg (44lbs) Drum 100kg (221lbs), 200kg (441lbs), 250kg (551lbs)

SMW

GMW

GTW

FCW

Metal-cored Wire

SAW Wire

SAW Flux