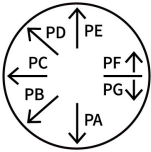


SC-91LP

Classification

**AWS** AWS A5.29 / ASME SFA-5.29 E91Ti-GM  
**EN** ISO 17632-A T50 4 1Ni P M21 1 H5

Welding Positions



Features

- Designed for welding with Ar+20~25%CO2 shielding gas
- Good performance in all positions (Pipe welding)
- Good impact value at low temperature

Polarity

DC +

Application Areas

- Pipe & Pipeline
- General fabrication
- Structural fabrication

Shielding Gas

Ar+20~25% CO2

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

| Shielding Gas | C    | Si   | Mn   | P     | S     | Ni   |
|---------------|------|------|------|-------|-------|------|
| Ar+20~25% CO2 | 0.05 | 0.40 | 1.40 | 0.011 | 0.011 | 0.90 |

Typical Mechanical Properties of All-Weld Metal

| Shielding Gas | Yield Strength<br>MPa(ksi) | Tensile Strength<br>MPa(ksi) | Elongation<br>(%) | Temperature<br>°C (°F) | Impact Toughness<br>J (ft · lbs) |
|---------------|----------------------------|------------------------------|-------------------|------------------------|----------------------------------|
| Ar+20~25% CO2 | 650 (94)                   | 690 (100)                    | 24                | -40 (-40)              | 65 (48)                          |

Diameter / Welding Parameters / Packaging

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

SMW

GMW

GTW

FCW

Metal-cored Wire

SAW Wire

SAW Flux