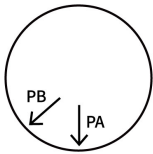


SC-80D2

Classification

**AWS** AWS A5.28/ ASME SFA-5.28 E80C-G  
**EN** ISO 17632-A T50 0 MnMo M M21 3

Welding Positions



Features

- Designed for welding with Ar+CO2 mixed gas
- High deposition rates & low slag coverage

Polarity

DC +

Application Areas

- Heavy equipment
- Petrochemical industry
- Pressure vessels

Shielding Gas

Ar+20~25% CO2

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

| Shielding Gas | C    | Si   | Mn   | P     | S     | Mo   |
|---------------|------|------|------|-------|-------|------|
| Ar+20~25% CO2 | 0.03 | 0.60 | 1.59 | 0.010 | 0.005 | 0.52 |

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 | 595 (86)                   | 662 (96)                     | 24.5              | 0 (32)                 | 58 (43)                          |

Diameter / Welding Parameters / Packaging

| Wire Diameter<br>mm(in) | Current<br>(A) |
|-------------------------|----------------|
| 1.2 (0.045)             | 140~300        |

SMW

GMAW

GTAW

FCAW

SAW Wire

SAW Flux

Metal-cored Wire