

SC-80MR

Classification

AWS AWS A5.28/ ASME SFA-5.28 E80C-G
EN ISO 17632-A T50 6 1.5Ni M M21 2 H5

Welding Positions



Features

- Designed for welding with Ar+CO2 mixed gas
- Suitable for Root-pass and multipass welding
- Good impact value at Low temperature(-60℃)

Polarity

DC+

Application Areas

- Structural fabrication
- Steel industry
- Heavy equipment & machinery
- Offshore structure

Shielding Gas

Ar+20~25% CO2

Approvals

DNV	LR	CE	TUV
✓	✓	✓	✓

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

Shielding Gas	C	Si	Mn	P	S	Ni
Ar+20~25% CO2	0.05	0.35	1.50	0.014	0.007	1.53

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature ℃ (°F)	Impact Toughness J (ft · lbs)
Ar+20~25% CO2	545 (79)	639 (93)	26.5	-60 (-75)	60 (44)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)
1.2 (0.045)	200~300

SMW

GMW

GTW

FCW

Metal-cored Wire

SAW Wire

SAW Flux