

SC-55F Cored

AWS A5.29 / ASME SFA5.29 E80T1-GC
JIS Z3313 T55 2 T15-0 C A-N1-U H10

TYPE : Semi-Metal

Applications

Butt and fillet welding of steel structures using 520MPa class high tensile steel such as construction machinery, buildings and bridges.

Characteristics on Usage

SC-55F Cored is a metal type flux cored wire which produces smooth arc characteristics and minimum spatter levels and excellent slag remove.

Notes on Usage

- ① Proper preheating(50~150°C)(122~302°F) and interpass temperature must be used in order to release hydrogen which may cause cracking in weld metal when electrodes are used for medium and heavy plates.
- ② Use 100% CO₂ gas.

Welding Position



1G (PA) 2F (PB)

Current

DC +

Shielding Gas

CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.05	0.48	1.56	0.012	0.010

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
580 (84,200)	625 (90,600)	24.5	-20 (-4)	60 (44)

Approval

I Packing(Including Ball Pac)

Dia. (mm)	1.2	1.4	1.6	Spool(kg)	12.5	15	20
(in)	.045	.052	1/16	(lbs)	28	33	44

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.2 (.045)	1.4 (.052)	1.6 (1/16)
F & HF	250 - 300	300 - 350	300 - 350