

SC-80M

TYPE : Metal-Cored

AWS A5.28/ ASME SFA5.28 E80C-G
EN ISO 17632-A T 46 4 M M 3 H5

Applications

SC-80M is used for welding in bridge construction, structural fabrication automated or robotic welding.

Characteristics on Usage

SC-80M is a metal cored wire designed for single or multipass welding on high-tensile steel and weathering grade steels. SC-80M was designed specifically to meet the demand for weld deposits that color match the low alloy, high strength weathering grade steels, such as Corten steel

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 Ar + 20 ~ 25% CO₂ gas.

Welding Position



1G 2F
(PA) (PB)

Current

DC +

Shielding Gas

Ar + 20~25% CO₂ gas.

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni	Cr	Cu
0.07	0.63	1.65	0.014	0.010	0.72	0.25	0.34

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)
610 (88,400)	658 (96,300)	24.5	-40 (-40)	60 (44)

Approval

I Packing(Including Ball Pac)

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

Sizes Available and Recommended Currents (Amp.)

Size mm(in)	1.2 (.045)	1.4 (.052)	1.6 (1/16)
F & HF	200~300	260~340	290~360
V-up, OH	100~150	140~180	150~180