

Applications

Typical industrial applications include machinery, bridge, structural fabrication and building.

Characteristics on Usage

- ① SC-91 is a rutile-type flux cored wire to be used with CO₂ gas shielding.
- ② Provide an exceptionally smooth and stable arc with a fast freezing slag system.
- ③ Bead shape and appearance are excellent in all position welding.

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 2F 3G 4G
 (PA) (PB) (PF) (PE)

Current

DC +

Shielding Gas

100%CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni
0.06	0.55	1.20	0.013	0.013	0.85

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	CVN-Impact Value J (ft · lbs)	
			0°C (32°F)	-20°C (-4°F)
645 (93,600)	660 (95,800)	24.0	100 (74)	70 (52)

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	260~320	290~350
V-up, OH	180~230	200~260	220~280
V-down	250~310	260~320	280~340