

# SC-91K2 Cored

TYPE : Rutile

AWS A5.29 / ASME SFA5.29 E91T1-K2C  
JIS Z3313 T57 4 T1-1 C A-N3 H10  
EN ISO 17632-A-T50 4 1.5Ni P C 1

## Applications

SC-91K2 Cored is designed for the welding of low alloy steel such as 600Mpa grade high strength steels HY-80, and ASTM A710, A514, A517.

## Characteristics on Usage

SC-91K2 Cored is a rutile type flux cored arc welding wire to be used with CO<sub>2</sub> shielding gas. Deposited weld metal toughness is good at low temperature range down -40° C(-40°F). To achieve good weld metal qualities, heat input must be controlled, not to exceed general welding condition.

Welding arc is stable and bead appearance is good in all position welding.

Diffusible hydrogen content is low and crack resistance is excellent.

## Notes on Usage

① Use 100% CO<sub>2</sub> gas.

## Welding Position



1G (PA) 2F (PB) 3G (PF) 4G (PE)

## Current

DC +

## Shielding Gas

CO<sub>2</sub>

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

C	Si	Mn	P	S	Ni	Mo
0.04	0.35	1.25	0.013	0.012	1.55	0.09

## Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
620 (90,000)	650 (94,500)	27	-20 (-4)	110 (82)
			-40 (-40)	60 (44)

## Approval

ABS

## I Packing

Dia. (mm) 1.2  
(in) .045

Spool(kg) 12.5 15 20  
(lbs) 28 33 44

## Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.2 (.045)
F & HF	200~300
V-up,OH	140~240