

SC-460

TYPE : Rutile

AWS A5.29 / ASME SFA5.29 E81T1-K2C
Z3313 T57 6 T1-1 C A-N3 H5
EN ISO 17632-A-T 46 6 1.5Ni P C 1 H5

Applications

SC-460 is suitable for single or multipass welding for low temperature service steel.

Characteristics on Usage

SC-460 is titania type of flux cored wire for all position welding. It provides excellent impact values at low temperature.

Notes on Usage

- ① Proper preheating(50~150°C)(122~302°F) and inter-pass 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 One-side welding defects such as hot cracking that may occur with wrong welding parameter such as high welding speed.
- ③ Use 100% CO₂ gas.

Welding Position



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

Current

DC +

Shielding Gas

CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni
0.06	0.35	1.20	0.008	0.011	1.50

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)	630 (91,000)	26.0	-60 (-76)	60 (44)

Approval

ABS, BV, DNV, GL, LR,
KR, NK

I Packing

Dia. (mm) 1.2 1.4
(in) .045 .052

Spool(kg) 5 15 20
(lbs) 28 33 44

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.2 (.045)	1.6 (1/16)
F & HF	120~290	150~350
V-up, OH	120~260	140~270
V-down	200~300	220~350