

SC-80K2

TYPE : Semi-Metal

AWS A5.29/ ASME SFA5.29 E80T1-K2C
JIS Z3313 T55 6 T15-0 C A-N3 H5
EN ISO 17632-A-T 46 6 1.5Ni R C 3 H5

Applications

SC-80K2 is designed for welding of low temperature service. Butt and fillet welding of offshore structures, LNG and LPG carriers and storage tanks, etc.

Characteristics on Usage

SC-80K2 is a metal type flux cored wire for high speed welding applications in the flat and horizontal fillet position.

Arc stability is excellent. Spatter loss is low and slag covering is uniform with good removability.

Notes on Usage

- ① Proper preheating(50~150°C)(122 ~ 302°F) and 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
(PA) (PB)

Current

DC +

Shielding Gas

CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni
0.05	0.40	1.31	0.011	0.010	1.45

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)
550 (79,900)	590 (85,700)	25	-30 (-22) -60 (-76)	90 (66) 53 (39)

Approval

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

I Packing

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

Spool(kg) 15
(lbs) 33

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.2 (.045)	1.4 (.052)
F	250 ~ 300	280 ~ 320
HF	250~ 300	280 ~ 320