SF-80MX

TYPE : Semi-Metal

AWS A5.29/ ASME SFA5.29 E80T1-GC
JIS Z3313 T55 2 T15-0 C A-N2 H10
EN ISO 17632-A-T 46 2 1Ni R C 3

Applications

As a metal type flux cored wired, Butt and fillet welding of steel structures using 590MPa class high tensile steel such as construction machinery, buildings and bridges.

Characteristics on Usage

SF-80MX is a metal type flux cored wire which produces smooth arc characteristics. It is used for joining from mild tensile steels to 590MPa class high tensile steels, and is suitable for both fillet and but welds, providing high deposition rates, combined with minimal spatter and excellent slag release.
Especially it has good anti-porosity to zinc-primer plate and mill scale plate in fillet 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% CO_2 gas.

Welding Position	Current	Shielding Gas
 1G (PA) 2F (PB)	DC +	CO_2

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni
0.06	0.55	1.42	0.015	0.010	1.00

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in²)	TS MPa(lbs/in²)	EL (%)	Temp. ℃ (℉)	CVN-Impact Value J (ft · lbs)
590 (85,600)	630 (91,400)	24.0	-20 (-4)	53 (39)

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	200~300	300~350	300~350

FCAW