

SC-80D2

TYPE : Metal-Cored

AWS A5.28 / ASME SFA5.28 E80C-G
JIS Z3318 YFM-G
EN ISO 17632-A-T 46 0 MnMo M M 3

Applications

SC-80D2 can be used on high strength steels and low alloy steels in heavy industries and structural steels.

Characteristics on Usage

SC-80D2 is a metal-cored gas shielded cored wire which combines the high deposition rates of a flux cored wire with the high efficiencies of a solid wire. SC-80D2 is equivalent to ER80S-D2 solid wire.

It provides an exceptionally smooth and stable arc, low spatter and minimal slag coverage.

Notes on Usage

① use Ar + 20~25% CO₂ gas.

Welding Position



1G 2F
(PA) (PB)

Current

DC +

Shielding Gas

Ar+20~25% CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Mo
0.05	0.60	1.65	0.012	0.010	0.51

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)
590 (85,600)	660 (95,700)	28	-20 (-4)	70 (52)

Approval

I Packing

Dia. (mm)	1.2	1.4	1.6	Spool(kg)	12.5	15	20
(in)	.039	.045	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	200~310	200~340	230~360