SC-91LP

TYPE : Rutile

AWS A5.29 / ASME SFA5.29 E91T1-GM
EN ISO 17632-A-T50 4 1Ni P M 1 H5

Applications

Typical industrial applications include shipbuilding, machinery, piping, bridge, structural fabrication and building.

Characteristics on Usage

① SC-91LP is a rutile-type flux cored wire to be used with Ar+CO_2 gas mixture shielding.
② Provide an exceptionally smoooth and stable arc with a fast freezing slag system, this wire is ideal for pipe welding.
③ Bead shape and appearance are excellent in all position welding.
④ It provide excellent notch toughness at low temperature.

Notes on Usage

① Proper preheating 50~150℃(122~302℉) 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 Ar+20~25%CO_2 gas.

Welding Position	Current	Shielding Gas
 1G (PA) 2F (PB) 3G (PF) 4G (PE)	DC +	Ar+20~25%CO_2

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni
0.05	0.40	1.40	0.013	0.006	0.90

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in²)	TS MPa(lbs/in²)	EL (%)	CVN-Impact Value J (ft · lbs) -20℃ (-4℉)	-40℃ (-40℉)
650 (94,300)	690 (100,000)	24.5	80 (59)	60 (44)

Approval

I Packing(Including Ball Pac)

Dia. (mm)	1.2	Spool(kg)	12.5	15	20
(in)	.045	(lbs)	28	33	44

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.2 (.045)
F & HF	120~300
V-up, OH	120~260
V-down	180~280