

SC-80MR

TYPE : Metal-Cored

AWS A5.28/ ASME SFA5.28 E80C-G
EN ISO 17632-A T 46 6 1.5Ni M M H5

Applications

SC-80MR is used for welding in offshore structure and heavy equipment and general structural fabrication.

Characteristics on Usage

SC-80MR is a metal cored wire designed for single-side welding and is also suitable for multi-pass welding in thick plate. SC-80MR provides an exceptionally smooth and stable arc, low spatter and minimal slag coverage and achieves good impact value to low temperature(-60°C).

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 Ar + 20~25% CO₂ gas.

Welding Position



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

Current

DC +

Shielding Gas

Ar + 20~25% CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni
0.07	0.35	1.55	0.014	0.010	1.55

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)
612 (88,700)	658 (95,400)	25.5	-60 (-76)	60 (44)

Approval

GL

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 & HF	200~300	260~340
V-up, OH	100~150	140~180