

Supercored 1CM

TYPE : Metal-Cored

AWS A5.28 / ASME SFA5.28 E80C-G
JIS Z3318 YF1CM-G
EN ISO 17634-A-T CrMo1 M M 3

Applications

Supercored 1CM can be used on 1.25%Cr-0.5%Mo steels. Recommended for welding of steam boiler plates and high temperature steels.

Characteristics on Usage

Supercored 1CM is a metal cored wire which combines the high deposition rates of F.C.W with the high efficiencies of a solid wire. It provides exceptionally smooth and stable arc, low spatter and minimal slag coverage.

Notes on Usage

- ① Proper preheating(130~165° 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 Keep the distance between tip and base metal at about 15mm.
- ③ 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	Cr	Mo
0.07	0.39	0.81	0.013	0.010	1.25	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)	Heat Treatment (°C × hr)
560 (81,300)	630 (91,000)	20	0 (32)	90 (66)	620 × 1hr
510 (74,100)	600 (87,100)	25	0 (32)	110 (81)	620 × 8hr

Approval

I Packing

Dia. (mm)	1.0	1.2	Spool(kg)	12.5	15
(in)	.039	.045	(lbs)	28	33

Sizes Available and Recommended Currents (Amp.)

Size mm(in)	1.0 (.039)	1.2 (.045)
F & HF	150~300	200~310