

# SC-91LP

Type : Rutile

## Conformances

AWS A5.36/ ASME SFA5.36 E91T1-M21A4-G  
 (AWS A5.29/ ASME SFA5.29 E91T1-GM)  
 EN ISO 17632-A-T 50 4 1Ni P M21 1 H5

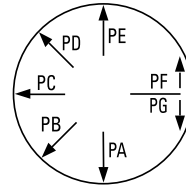
## Applications

- Pipe Line
- Structural fabrication

## Features

- Designed for welding with Ar + 20~25% CO<sub>2</sub> shielding gas
- Good bead appearance
- Good performance in all positions (Orbital welding)
- Good impact value at low temperature

## Welding Position



## Current

DC +

## Shielding Gas

Ar + 20~25% CO<sub>2</sub>

## Diameter / Packaging

Diameter	Spool		
	5kg (11lbs)	15kg (33lbs)	20kg (44lbs)
1.2 (0.045)	√	√	√

## 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/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)
650 (94,300)	690 (100,000)	24.5	-20 (-4) -40 (-40)	80 (59) 60 (44)

## Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Melt-off Rate kg/hr (lb/hr)
1.2mm (0.045 in) DC+					
80% Ar + 20% CO <sub>2</sub>	25 (1)	4.4~10.2 (175~400)	130~275	23~30	1.8~4.1 (4.0~9.0)