

SC-81B2

Type : Rutile

Conformances

AWS A5.36/ ASME SFA5.36 E81T1-C1PZ-B2

(AWS A5.29/ ASME SFA5.29 E81T1-B2C)

EN ISO 17632-A-T CrMo1 P C1 2

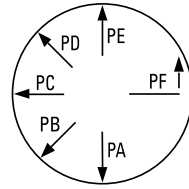
Applications

- Petrochemical industry
- Pressure vessel

Features

- Stable arc and low spatter level

Welding Position



Current

DC +

Shielding Gas

100% CO₂

Diameter / Packaging

Diameter	Spool			Pac		
	5kg (11lbs)	15kg (33lbs)	20kg (44lbs)	100kg (221lbs)	200kg (441lbs)	250kg (551lbs)
1.2 (0.045)		✓				
1.4 (0.052)		✓				
1.6 (1/16)		✓				

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Mo
0.066	0.41	0.83	0.016	0.017	1.19	0.51

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	PWHT
575 (83,500)	656 (95,200)	22.4	690±15°C X 1Hr

Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)	Efficiency (%)
1.2mm (0.045 in) DC+						
100% CO ₂	20~25 (51/64~1)	10.2 (400)	180~220	25~27	3.4 (7.5)	84~87
		11.5 (450)	230~270	27~29	4.5 (9.9)	85~88
		15.3 (600)	280~320	32~34	5.2 (11.4)	86~88
1.4mm (0.052 in) DC+						
100% CO ₂	20~25 (51/64~1)	7.6 (300)	230~270	27~29	3.9 (8.6)	85~87
		10.2 (400)	280~320	31~33	4.8 (10.6)	85~88
		12.8 (500)	310~350	35~37	5.8 (12.8)	86~89
1.6mm (1/16 in) DC+						
100% CO ₂	20~25 (51/64~1)	6.4 (250)	260~300	30~32	4.2 (9.2)	85~88
		7.6 (300)	310~350	32~34	4.8 (10.6)	86~88
		8.1 (320)	330~370	33~35	5.3 (11.7)	87~89
		9.2 (360)	380~420	37~39	5.7 (12.5)	87~90

SMAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX