

Supercored 1CM

Type : Metal-Cored

Conformances

AWS A5.36/ ASME SFA5.36 E80T15-M21PZ-G(B2)

(AWS A5.28/ ASME SFA5.28 E80C-G)

JIS Z3318 YF1CM-G

EN ISO 17634-A-T CrMo1 M M21 3

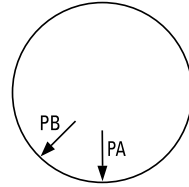
Applications

- Petrochemical industry
- Pressure vessel

Features

- Smooth and stable arc
- Low spatter
- Good porosity resistance

Welding Position



Current

DC +

Shielding Gas

Ar + 20~25% CO₂

Diameter / Packaging

Diameter	Spool			Pac		
	5kg (11lbs)	15kg (33lbs)	20kg (44lbs)	250kg (551lbs)	300kg (661lbs)	350kg (771lbs)
mm (in)						
1.2 (0.045)	√	√	√	√	√	√

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)	PWHT
560 (81,300)	630 (91,400)	20	0 (32)	90 (66)	620/1Hr
510 (74,100)	600 (87,100)	25	0 (32)	110 (81)	620/8Hr

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+						
Flat & Horizontal						
80% Ar + 20% CO ₂	19-25 (3/4-1)	9.5 (374)	230-250	26-29	3.9 (8.6)	90-96
		12.2 (480)	280-300	28-31	5.3 (11.6)	
		14.8 (582)	320-340	30-33	6.5 (14.2)	

SMW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX