

SC-81B2

Type : Rutile

Conformances

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

EN ISO 17632-A-T CrMo1 P C 2

Applications

- Petrochemical industry
- Pressure vessel

Features

- Stable arc and low spatter level

Welding Position



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

Current

DC +

Shielding Gas

100% CO₂

Diameter / Packaging

Diameter	Spool
mm (in)	15kg (33lbs)
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 Operating Procedures

Diameter in (mm)	Amp-Volt Range	Typical	Stickout in (mm)
1.2 (0.045) DC+	150 - 260A 24-30V	200A 26V	15 - 25 (5/8 - 1)
1.4 (0.052) DC+	180 - 280A 25-32V	220A 26V	15 - 25 (5/8 - 1)
1.6 (1/16) DC+	200 - 300A 25-32V	240A 27V	15 - 25 (5/8 - 1)