

# SC-91P

Type : Rutile

## Conformances

AWS A5.36M/ ASME SFA5.36M E621T1-M21A0-G  
 (AWS A5.29/ ASME SFA5.29 E91T1-GM)  
 EN ISO 18276-A-T 55 0 Z P M21 1

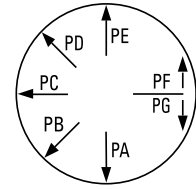
## Applications

- 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)

## 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	Mo
0.05	0.45	1.30	0.013	0.010	0.85	0.22

## 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)
640 (92,900)	680 (98,700)	26.0	0 (32)	80 (59)

## 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)

SMW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX