

SC-110M Cored

TYPE : Metal-Cored

AWS A5.28 / ASME SFA5.28 E110C-G
EN ISO 18276-A-T 69 4 Mn2NiMo M M 3

Applications

Single and multipass welding of high strength low alloy steels, such as HY-80, and HY-100.

Characteristics on Usage

SC-110M Cored is a metal cored wire which provides an exceptionally smooth and stable arc, low spatter and minimal slag coverage.

Notes on Usage

- ① Proper preheating(50~150°C)(122~302°F) and interpass temperature must be used in order to release hydrogen which may cause cracking in weld metal when electrodes are used for medium and heavy plates.
- ② One-side welding defects such as hot cracking may occur with wrong welding parameter such as high welding speed.
- ③ Use Ar+20-25% CO₂ gas.

Welding Position



1G (PA) 2F (PB)

Current

DC +

Shielding Gas

Ar+20~25%CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo
0.04	0.70	1.80	0.015	0.015	2.0	0.10	0.60

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)
760 (110,200)	820 (119,000)	20	-51 (-60)	45 (34)

Approval

I Packing

Dia. (mm)	1.2	Spool(kg)	12.5	15	20
(in)	.045	(lbs)	28	33	44

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.2 (.045)
F & HF	220 ~ 290

Diam.	15kg Spool
1.2mm	HKSC-110M12

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