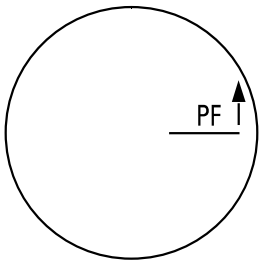
SC-EG2 Cored

Type : Metal-Cored

Conformances

AWS A5.26/ ASME SFA5.26 EG70T-2C
JIS Z3319 YFEG-22C
KR 3V, 3YV
ABS 3, 3YH10
LR 3, 3Y
BV AV3, AV3Y
DNV·GL IIY (-20°C)
NK KEW53
CCS 3, 3Y
RINA 3Y

Welding Position



Current

DC +

Applications

- Shipbuilding
- Storage tank

Shielding Gas

100% CO_2

Features

- Electro gas arc welding process
- Hig deposition(Vertical up butt welding)

Diameter / Packaging

Diameter	Spool	
mm (in)	15kg (33lbs)	20kg (44lbs)
1.6 (1/16)	√	√

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Mo
0.08	0.3	1.52	0.012	0.010	0.12

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in²)	TS MPa(lbs/in²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft·lbs)
510 (74,000)	560 (81,300)	27	-20 (0)	60 (44)

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 (%)
1.6mm (1/16 in) DC+						
100% CO_2	25 (1)	8.3 (327)	330	32	5.8 (12.8)	92~94
		8.8 (346)	350	34	6.6 (14.6)	92~94
		9.8 (386)	380	38	7.1 (15.7)	93~95