

# SC-110M Cored

Type : Metal-Cored

## Conformances

AWS A5.36/ ASME SFA5.36 E110T15-M21A6-G  
(AWS A5.28/ ASME SFA5.28 E110C-G)  
EN ISO 18276-A-T 69 4 Mn2NiMo M M21 3 H5

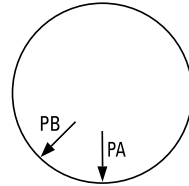
## Applications

- High tensile welded structure
- Shipbuilding
- Heavy equipment

## Features

- Good performance and low spatter
- Smooth and stable arc with a fast freezing slag
- Pre-heat recommended
- Good anti-porosity

## Welding Position



## Current

DC +

## Shielding Gas

Ar + 20~25% CO<sub>2</sub>

## 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	Ni	Mo
0.04	0.70	1.80	0.015	0.015	0.10	2.00	0.60

**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)
730 (105,900)	800 (116,100)	20	-50 (-58)	40 (30)

**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 (%)
<b>1.2mm (0.045 in) DC+</b>						
<b>Flat &amp; Horizontal</b>						
80% Ar + 20% CO <sub>2</sub>	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)	

SWAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX