

SC-460M

Type : Metal-Cored

Conformances

AWS A5.18/ASME SFA5.18 E70C-6M

EN ISO 17632-B-T 55-4 T 15-1 M21 (M20) A H5

- General fabrication
- Heavy equipment

CWB CSA W48- E491C-6M1-H4

Features

- Semi-automatic and automatic applications
- Good anti-porosity

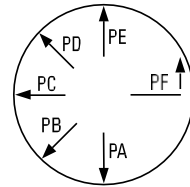
Features

- Semi-automatic and automatic applications
- Good anti-porosity

Diameter /Packaging

Diameter	Spool				Pac	
	15kg (33lbs)	20kg (44lbs)	250kg (551lbs)	300kg (661lbs)	350kg (771lbs)	420kg (925lbs)
1.2 (0.045)	√	√	√	√	√	√
1.4 (0.052)	√	√	√	√	√	√
1.6 (1/16)	√	√	√	√	√	√

Welding Position



Current

DC+

Shielding Gas

Ar + 10~25%CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni
0.040	0.51	1.58	0.011	0.008	0.35

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)
486 (70,000)	580 (84,000)	28.8	-40 (-40)	35 (26)

Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm(in)	Wire Feed Speed m/min (in/min)	Am p. (A)	Vol t. (V)	Deposition Rate kg/hr (lb/hr)	Efficien cy (%)
1.2mm (0.045in) DC+						
80% Ar + 20% CO ₂	19-25 (3/4-1)	Flat & Horizontal				
		7.3 (288)	190-210	22-26	3.4 (7.6)	90-96
		9.7 (382)	240-260	23-27	4.5 (9.7)	
12.2 (489)	280-310	24-30	5.9 (12.8)			
1.4mm (0.052in) DC+						
80% Ar + 20% CO ₂	19-25 (3/4-1)	Flat & Horizontal				
		6.7 (261)	250-270	22-26	3.8 (8.3)	91-96
		7.8 (307)	290-310	25-31	4.9 (10.4)	
9.4 (370)	330-350	28-32	5.5 (12.0)			
1.6mm (1/16in) DC+						
80% Ar + 20% CO ₂	25-32 (1-1 1/4)	Flat & Horizontal				
		5.6 (220)	290-310	26-32	4.5 (9.3)	92-96
		6.8 (270)	340-350	29-33	5.6 (12.1)	
7.8 (310)	350-370	31-34	6.7 (14.3)			

W SMA
 W SA
 W GMA
 W GTA
 FCA
 Non-Ferrous
 APPEN DIX