

Conformances

AWS A5.36 / ASME SFA5.36 E71T8-A2-CS3 H8

(AWS A5.20/ ASME SFA5.20 E71T-8 H8)

EN ISO 17632-A-T 42 3 Y NO 2 H10

CE

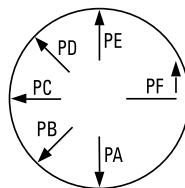
Applications

- General fabrication
- Bridge & Civil construction
- Shipbuilding
- AWS D1.8 Seismic requirements

Features

- Excellent mechanical properties
- Easy slag removal
- Excellent resistance to cracking
- Suitable for outdoor welding

Welding Position



Current

DC -

Shielding Gas

No shielding gas

Diameter / Packaging

Diameter mm (in)	Spool		Coil	Bucket
	12.5kg (28lbs)	15kg (33lbs)	25kg (55lbs)	19.5kg Sealed (6.5kg Basket)
1.6 (1/16)	✓	✓		✓
1.8 (0.072)	✓	✓		✓
2.0 (5/64)	✓	✓	✓	✓

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Al
0.16	0.15	0.63	0.003	0.003	0.48

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)
447 (64,800)	565 (82,000)	32	-30 (-22)	65 (48)

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-						
No shielding gas	25 (1)	4.0 (160)	190~220	18~21	1.7 (3.7)	75~79
		4.8 (190)	210~240	20~22	2.0 (4.4)	
		5.4 (215)	230~260	21~23	2.4 (5.2)	
		6.4 (255)	250~280	22~23	2.7 (5.9)	
1.8mm (0.072 in) DC-						
No shielding gas	25 (1)	3.8 (150)	220~250	21~23	2.6 (5.7)	79~83
		4.3 (170)	250~280	22~23	2.9 (6.3)	
		5.4 (215)	280~310	23~24	3.7 (8.1)	
2.0mm (5/64 in) DC-						
No shielding gas	25 (1)	3.0 (120)	230~260	21~23	2.4 (5.2)	77~81
		3.9 (155)	260~290	22~23	3.0 (6.6)	
		5.2 (205)	290~320	23~24	3.8 (8.3)	