



# SF-80W

AWS A5.29 / ASME SFA5.29 E81T1-W2  
JIS Z3320 YFA-58W

## Applications

SF-80W is designed for the welding of weather-proof steel for example corten A-242 or A-588. Mainly used for flat and horizontal fillet welding on structural exposed steel usually found on buildings and bridges.

## Characteristics on Usage

SF-80W is a titania type flux cored wire which can be used for all welding in conjunction with CO<sub>2</sub> shielding gas.

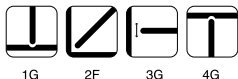
## Notes on Usage

- 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 100% CO<sub>2</sub> gas.
- ④ Refer to page 168 for storage instructions.

## Welding Position

## Current

## Shielding Gas



1G

2F

3G

4G

DC +

CO<sub>2</sub>

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni	Cu
0.04	0.40	0.92	0.016	0.012	0.50	0.50	0.40

## Typical Mechanical Properties of All-Weld Metal

Y.S N/mm <sup>2</sup> (lbs/in <sup>2</sup> )	T.S N/mm <sup>2</sup> (lbs/in <sup>2</sup> )	EL. (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
530 (77,000)	610 (88,600)	26	-30 (-22)	40 (30)

## Approval

## Packing (Including Ball Pac)

Dia. (mm)	1.2	1.4	1.6	Spool (kg)	12.5	15	20
(in)	.045	.052	1/16	(lbs)	28	33	44
Ball Pac							

Size mm (in)	1.2 (.045)	1.4 (.052)	1.6 (1/16)
F & HF	200~300	250~350	300~400
V-up, OH	120~260	140~270	180~280
V-down	200~300	250~350	300~400