

Tru-Core® MC 80C-Ni1 AWS E80C-Ni1 H4

DESCRIPTION

Tru-Core® MC 80C-Ni1 is a low alloy steel, composite metal cored electrode for gas shielded arc welding low alloy, and certain carbon, steels requiring tensile strengths in excess of 80 ksi and good CVN values at temperatures as low as -50°F. This electrode is intended to be used with a shielding gas blend of 95-99% Argon/Balance Oxygen, but performs well with 75-95% Argon/Balance Carbon Dioxide as well. The MC 80C-Ni1 can be used in single and multiple pass applications, both in fillets and groove welds.

CHARACTERISTICS

PRODUCT FEATURES:

- Excellent mechanical properties
- Nearly slag free welds
- Flat bead geometry
- Smooth arc transfer
- Easy clean-up
- Excellent feedability
- Good low-temperature CVN properties
- Better sidewall fusion than solid electrodes

PRODUCED IN: Stillwater, Oklahoma

SPECIFICATIONS

Meets or exceeds:

- AWS A5.28: E80C-Ni1 H4
- ASME SFA 5.28: E80C-Ni1 H4

APPLICATIONS

Tru-Core® MC 80C-Ni1 is a good choice to weld steels from ¼" thickness up to heavy plates sections. Typical grades: ASTM A203 Grade A, ASTM A352 Grades LC1 and LC2, and Weathering steel such as ASTM A588. Some examples are:

- Power transmission poles
- Mining machinery
- Construction equipment
- Shipbuilding

SHIELDING GAS BLENDS

Typical Application Shielding Gas Blends:

- 95-99% Argon/Balance O₂
- 75-95% Argon/Balance CO₂
- Flow Rate: 35-45 CFH

WELDING POSITIONS

All position welding is possible when using the correct shielding gas blends, welding process and welding parameters.

STORAGE

Welding wire should be stored in a dry, enclosed environment and in its originally-sealed package.

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