



Please Note: Chemistry listed below for wire/strip are typical values only.

Spoolarc 80

EL12

Spoolarc 80 is a low manganese and silicon wire. It provides excellent ductility and crack resistance. Typical applications include lap welds, build-up, or repair welding prior to machining.

C	Mn	Si	P	S	Cr	Ni	Mo	Other
0.10	0.44	0.04	0.003	0.014	-	-	-	-

Spoolarc 81

EM12K

Spoolarc 81 is a medium manganese and silicon wire with nominal rust and mill scale tolerance. Typical applications include structural steels, medium strength pressure vessels, wind tower bases, ship, barge, and offshore oil rig fabrication.

C	Mn	Si	P	S	Cr	Ni	Mo	Other
0.11	0.95	0.26	0.006	0.008	-	-	-	-

Spoolarc 29S

EM13K

Spoolarc 29S is a general purpose copper-coated solid wire suitable for many carbon steel welding applications using either the MIG/Gas Metal Arc Welding (GMAW) or the Submerged Arc Welding (SAW) processes. Spoolarc 29S contains moderate amounts of manganese and silicon to provide sufficient deoxidation over light mill scale. Shielding gas choices for Spoolarc 29S in the GMAW mode are 100% carbon dioxide, argon/carbon dioxide mixtures, argon/oxygen mixtures, and other argon based mixed gas blends. In the SAW mode, Spoolarc 29S can be combined with a variety of active and neutral bonded fluxes to achieve better welding performance over Spoolarc 81 wire. Spoolarc 29S is used in a wide variety of applications including heavy equipment, automotive parts, railcars, agricultural equipment, and sheet metal welding.

C	Mn	Si	P	S	Cr	Ni	Mo	Other
0.09	1.10	0.52	0.008	0.012	-	-	-	-

Spoolarc 71

EM14K

ESAB's **Spoolarc 71** is a medium manganese and silicon subarc wire that has been microalloyed with titanium. Used with 429, OK 10.62, and OK 10.71 fluxes Spoolarc 71 will produce weld deposits with a minimum 70,000 psi tensile strength in the as welded condition or after eight-hours of stress relief. When used with OK 10.62 weld deposits meet ASME A No. 1 chemistry requirements. Spoolarc 71 is used for welding pressure vessels and can be used for other applications requiring good mechanical properties after stress relieving.

C	Mn	Si	P	S	Cr	Ni	Mo	Other
0.10	1.22	0.55	0.008	0.005	-	-	-	Ti0.07

Spoolarc 53

EH12K

Spoolarc 53 is designed for single or multipass welding on carbon and low alloy steels. It provides higher strength deposits and good impact toughness.

C	Mn	Si	P	S	Cr	Ni	Mo	Other
0.11	1.50	0.36	0.008	0.010	-	-	-	-

Spoolarc 36

EH14

Spoolarc 36 is a high manganese wire for single or multipass welding. Typical applications include seam welding on hot water tanks, valves, fittings, and heavy vessel fabrication.

C	Mn	Si	P	S	Cr	Ni	Mo	Other
0.16	1.96	0.02	0.014	0.016	-	-	-	-