

SF-30_xSW-316/316L

AWS A5.39 ER316/316L
EN ISO 14343-A S 19 12 3 L
GB -

SUBERED ARC WELDING WIRE AND FLUX FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SW-316L is low carbon 18%Cr-12%Ni-2.5%Mo, designed for welding SUS316 grade stainless steel.
- With appropriate contents of ferrite and Molybdenum(Mo) in weld metal, due to that the characteristic of excellent corrosion resistibility, excellent slag removal and smooth bead appearance.

NOTE ON USAGE :

- SF-30 is an agglomerated flux. Rebake flux at 350°C for 1hour after opening use.
- Appropriate new flux is required to add with the recycling used flux to maintain welding quality.

TYPICAL CHEMICAL COMPOSITION OF WELD METAL :

C	Mn	Si	P
0.02	1.50	0.41	0.023
S	Ni	Cr	Mo
0.008	11.21	19.11	2.60

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	
550(56.1)	
ELONGATION RATE %	IMPACT VALUES -196 °C J(Kgf-m)
40	40(4.1)

SF-33_xSW-2209

AWS A5.39 ER2209
EN ISO 14343-A S 22 9 3 N L
GB -

SUBERED ARC WELDING WIRE AND FLUX FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SW-2209 is low carbon 22%Cr-9%Ni-3%Mo-N, designed for welding UNS S31803(Alloy2205) grade stainless steel.
- With appropriate contents of austenitic and ferrite. It can obtain better impact toughness and excellent corrosion resistibility.

NOTE ON USAGE :

- SF-33 is an agglomerate flux. Rebake flux at 300°C for 1hour after opening use.
- Lower current is recommended and temperature of interpass controlled under 120°C.
- Appropriate new flux is required to add with the recycling used flux to maintain welding quality.

TYPICAL CHEMICAL COMPOSITION OF WELD METAL :

C	Mn	Si	P	S
0.03	1.27	0.49	0.026	0.010
Ni	Cr	Mo	N	
8.94	22.04	2.85	0.14	

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %
815(83.2)	25