

Nickel alloy SAW welding

DESCRIPTION & APPLICATIONS :

- SF-34XSW-276 is 57% Ni-16% Cr-15. 5% Mo-5. 5% Fe-4% W submerged arc welding material, suitable for Inconel 276, ASTM A553M TYPE1, UNS N10276 and other base metals.
- Welding slag has good peeling property and smooth appearance of welding channel.
- And with SF-34 welding flux, the metal content of weld bead itself will be maintained in a stable state, and excellent welding performance will be displayed.

NOTE ON USAGE :

- SF-34 belongs to alkaline welding flux. After unpacking, please put it in the furnace and dry it at 350 °C for 1 hour. Pay attention to keep it dry to prevent pores.
- When the bottom layer is welded, the current should not be too high to avoid cracking of weld bead.
- When the welding flux is recycled and reused, please add a proper amount of new welding flux for mixed use to ensure good quality of weld.

TYPICAL CHEMICAL COMPOSITION OF WELD METAL :

C	Mn	Si	P	S	Ni	Cr	Mo	W	Fe
0.018	0.55	0.21	0.006	0.002	56.30	15.30	16.2	3.6	6.2

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YIELD POINT N/mm ² (Kg/mm ²)	ELONGATION RATE %	IMPACT VALUES -196 °C J(Kgf-m)
723(73.8)	42	90(9.2)