SF-38xSW-M12K

AWS A5.17 F7A2-EM12K
EN ISO 14171-A S 38 2 AB S2Si
GB T5293 F5A3-H08MnA

SUBMERGED ARC WELDING WIRE AND FLUX FOR 490N/mm² HIGH TENSILE STEEL

DESCRIPTION & APPLICATIONS :

- Nice welding beac appearance, good slag removal and recommended for single or dual pass welding.
- Suitable for steel frames, H beam and general steel structure.

NOTE ON USAGE :

- SF-38 is an acid type flux. Re-dry the flux at 350˚C for 1hr prior to use.
- Lower current is recommended for welding first pass.
- Appropriate new flux is required to add with the recycling used flux for maintain the welding quality.

TYPICAL CHEMICAL COMPOSITION OF WELD METAL :

C	Mn	Si	P	S
0.06	1.20	0.61	0.021	0.010

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YP N/mm²(Kgf/mm²)	TS N/mm²(Kgf/mm²)
415(42.3)	525(53.6)
EL %	**IV -20˚C/-30˚C J(Kgf-m)**
31	49(5.0)/32(3.3)

SF-65xSW-M12K

AWS A5.17 F7A2-EM12K
EN ISO 14171-A S 42 3 AB S2Si
GB T5293 F5A3-H08MnA

SUBMERGED ARC WELDING WIRE AND FLUX FOR 490N/mm² HIGH TENSILE STEEL

DESCRIPTION & APPLICATIONS :

- Suitable for thickness plates in deep groove applications. It is designed for multi-pass welds.
- Typical applications include pressure vessels, ship building, bridge and steel structures.

NOTE ON USAGE :

- SF-65 is a neutral flux and need to be re-dry at 350˚C for 1hr prior to use.
- Lower current is recommended for welding first pass.
- Appropriate new flux is required to add with the recycling used flux for maintain the welding quality.

TYPICAL CHEMICAL COMPOSITION OF WELD METAL :

C	Mn	Si	P	S
0.07	1.50	0.60	0.018	0.006

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YP N/mm²(Kgf/mm²)	TS N/mm²(Kgf/mm²)
460(46.9)	560(57.1)
EL %	**IV -30˚C J(Kgf-m)**
30	55(5.6)