

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-66 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
0.09	1.62	0.30	0.015	0.004

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YP N/mm ² (Kgf/mm ²)	TS N/mm ² (Kgf/mm ²)	EL %
490(50.0)	570(58.2)	32
465(47.4)	520(53.1)	34
IV -50°C/-62°C J(Kgf-m)		HEAT TREATMENT
72(7.3)/50(5.1)		Welding process
88(9.0)/68(6.9)		620°Cx1hr