

## FLUX CORE WIRES FOR 490N/mm<sup>2</sup> HIGH TENSILE STEEL

### DESCRIPTION & APPLICATIONS :

- SFC-04 is a self-shielded flux cored wire designed for on site fabrications with welder could use it outdoor at the applications with longer stick-out than normal fcaw if wind is not high.
- Excellent performance in desulfuration reduces porosity effectively, with nice bead appearance and slag removal easily.
- It is commonly used for steel structure, steel frames with groove and fillet welding.

### NOTE ON USAGE :

- Use DC(+) polarity.

### WELDING POSITION :



### TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Al
0.22	0.65	0.35	0.010	0.003	1.70

### TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YP N/mm <sup>2</sup> (Kgf/mm <sup>2</sup> )	TS N/mm <sup>2</sup> (Kgf/mm <sup>2</sup> )	EL %
458(46.3)	575(58.7)	23

### SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Diameter (mm)	2.0	2.4
Parameters		
Voltage(Volt)	25-35	25-39
Current (Amp)	200-350	200-400
Stickout(m/m)	30-50	30-50