

FLUX CORE WIRES FOR 490N/mm² HIGH TENSILE STEEL

DESCRIPTION & APPLICATIONS :

- SFC-07 is a self-shield flux cored wire.
- Excellent performance in good penetration, fluidity of deposition rate, nice welding bead appearance and slag removal easily. DO NOT for impact usage.
- Suitable for mild steel and high tensile steel plates welding.

NOTE ON USAGE :

- Use DC (-) polarity.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Al
0.23	0.38	0.1	0.008	0.003	1.80

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YP N/mm ² (Kgf/mm ²)	TS N/mm ² (Kgf/mm ²)	EL %
486(49.6)	582(59.4)	23

SIZE AND RECOMMENDED CURRENT RANGE : DC(-)

Diameter (mm) Parameters	1.6	2.0	2.4
Voltage(Volt)	22-27	23-30	27-32
Current (Amp)	150-300	250-450	250-550
Stickout(m/m)	30-40	30-40	35-50