

FLUX CORED WIRES FOR $\geq 550\text{N/mm}^2$ HIGH TENSILE STEEL

DESCRIPTION & APPLICATIONS :

- SFC-101 is a high tensile strength flux cored wire designed for high tensile steel carries 690N/mm^2 .
- Suitable for petro-chemical industry, oil refinery components, pipes.

NOTE ON USAGE :

- Use DC (+) polarity. CO_2 gas (min. 99.8%) G.F.R: 15~25 l/min.
- Pre-heat the workpiece at temp. $220\sim 350^\circ\text{C}$.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) : (CO_2)

C	Mn	Si	P	S	Ni	Cr	Mo
0.06	1.21	0.45	0.021	0.012	0.63	0.35	0.41

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (CO_2)

YIELD POINT $\text{N/mm}^2(\text{Kgf/mm}^2)$	TENSILE STRENGTH $\text{N/mm}^2(\text{Kgf/mm}^2)$	ELONGATION RATE %
660(67.3)	721(73.6)	22

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Parameters \ Diameter (mm)	1.2		1.4		1.6	
	F	V	F	V	F	V
Voltage (Volt)	25-36	25-26	28-38	25-28	30-40	26-30
Current (Amp)	150-300	150-220	180-350	150-230	200-400	160-250
Stickout (m/m)	10-15		15-20		15-30	
Gas flow (l/min)	15-25		15-25		15-25	