

FLUX CORE WIRES FOR 490N/mm² HIGH TENSILE STEEL

DESCRIPTION & APPLICATIONS :

- SFC-18 is an all-positional self-shielded flux cored wire.
- Good penetration, high deposition rate, fluidity of deposit metal, good welding bead appearance, slag removal easily and anti-crack with all-positional welding.
- It is suitable for structural welding outdoors, such as steel structures, chimney, pipes, etc.

NOTE ON USAGE :

- Use DC (-) polarity.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Al
0.15	0.60	0.13	0.007	0.004	0.70

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YP N/mm ² (Kgf/mm ²)	TS N/mm ² (Kgf/mm ²)	EL %	IV -30 °C J(Kgf-m)
442(45.1)	553(56.4)	24	47

SIZE AND RECOMMENDED CURRENT RANGE : DC(-)

Parameters \ Diameter (mm)	2.0
Voltage(Volt)	18-25
Current (Amp)	150-350
Stickout(m/m)	30-40