

FLUX CORED WIRES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SFC-307 is a full austenitic structure, the weld metal contains 19%Cr-9%Ni-4%Mn.
- It is suitable for clad stainless steel, high tensile steel, steels difficult to weld, nuclear submarine, and armor plate at a non-magnetic site.

NOTE ON USAGE :

- Use CO₂ within gas purity of 99.8% upward for gas shield, and the flow with 20~25 l/min.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) : (CO₂)

C	Mn	Si	P	S	Ni	Cr	Mo
0.045	4.50	0.60	0.023	0.004	9.20	19.50	0.8

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (CO₂)

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %
610(62.2)	37

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Parameters	Diameter (mm)	1.2		1.6	
		F, H	V, OH	F, H	V, OH
Voltage (Volt)		23-36	22-26	28-36	-
Current (Amp)		130-250	120-160	180-300	-