

FLUX CORED WIRES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SFC-308H is an austenitic structure, the weld metal contains 19%Cr-9%Ni.
- Advantage of anti-tension strength and creep strength in the high temp. environment.
- It is suitable for Petrol Chemical Industry, Pressure Vessel, Food and Beverage Machinery, and the stainless steels such as AISI 301, 302, 304S, 304H, and SUS 304.

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
0.049	1.55	0.53	0.026	0.002	9.80	20.20

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (CO₂)

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %
573(58.5)	40

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	-