

FLUX CORED WIRES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SFC-308L is an austenitic structure, the weld metal contains 19%Cr-9%Ni.
- It is suitable for Petrol Chemical Industry, Pressure Vessel, Food and Beverage Machinery, and the stainless steels such as AISI 301, 302, 304S, and SUS 304, 304L.

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
0.031	1.10	0.70	0.024	0.007	9.83	19.72

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (CO₂)

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %	IMPACT VALUES -196 °C J(Kgf-m)	SIDE EXPANSION (mm)
562(57.3)	42	32(3.3)	1.02

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Parameters	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	-