

FLUX CORED WIRES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SFC-309MoL is an austenitic structure, the weld metal contains 22%Cr-12%Ni-2%Mo.
- Good weldability, the corrosion and heat resistances better than SFC-309L.
- It is suitable for dissimilar joints welding in the stainless steel 316 and carbon steel, the SUS 316, 316L composite steel overlay bottom welding.

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
0.030	1.25	0.71	0.025	0.001	13.60	23.40	2.43

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (CO₂)

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %
730(74.5)	27

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	—