

FLUX CORED WIRES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SFC-312 is an austenitic structure, the weld metal contains 29%Cr-9%Ni.
- Contains more Cr for oxidization resistance and lower cracking sensitivity.
- It is suitable for dissimilar joints welding in stainless steel and carbon steel, welding difficulty, blowhole possibility, and toughness alloy.

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
0.058	0.875	0.518	0.021	0.004	9.25	30.40

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (CO₂)

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %
745(76.0)	24

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	-