

FLUX CORED WIRES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SFC-316L is an austenitic structure, the weld metal contains 18%Cr-12%Ni-2%Mo.
- It possesses better corrosion resistance, especially in dilute sulfuric acid.
- It is suitable for chemical container as AISI 316/316L, SUS 316/316L steels.

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
0.028	1.00	0.65	0.025	0.002	11.50	18.10	2.50

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)
540(55.1)	40	30(3.1)	0.70mm

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	-